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PROCESS CHARACTERIZATION
TASK ORDER NO. 1

BOOK 3 OF 5

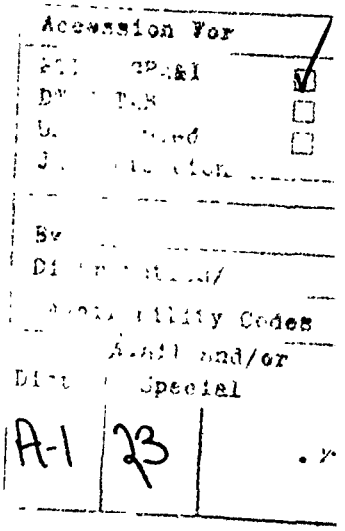
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OO-ALC

MANPWW

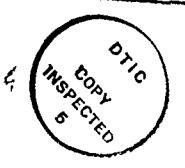
(MAIN LANDING GEAR EXCEPT C5 - WCD'S)

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15 DECEMBER 1989



CONTRACT NO. F33600-88-D-0567
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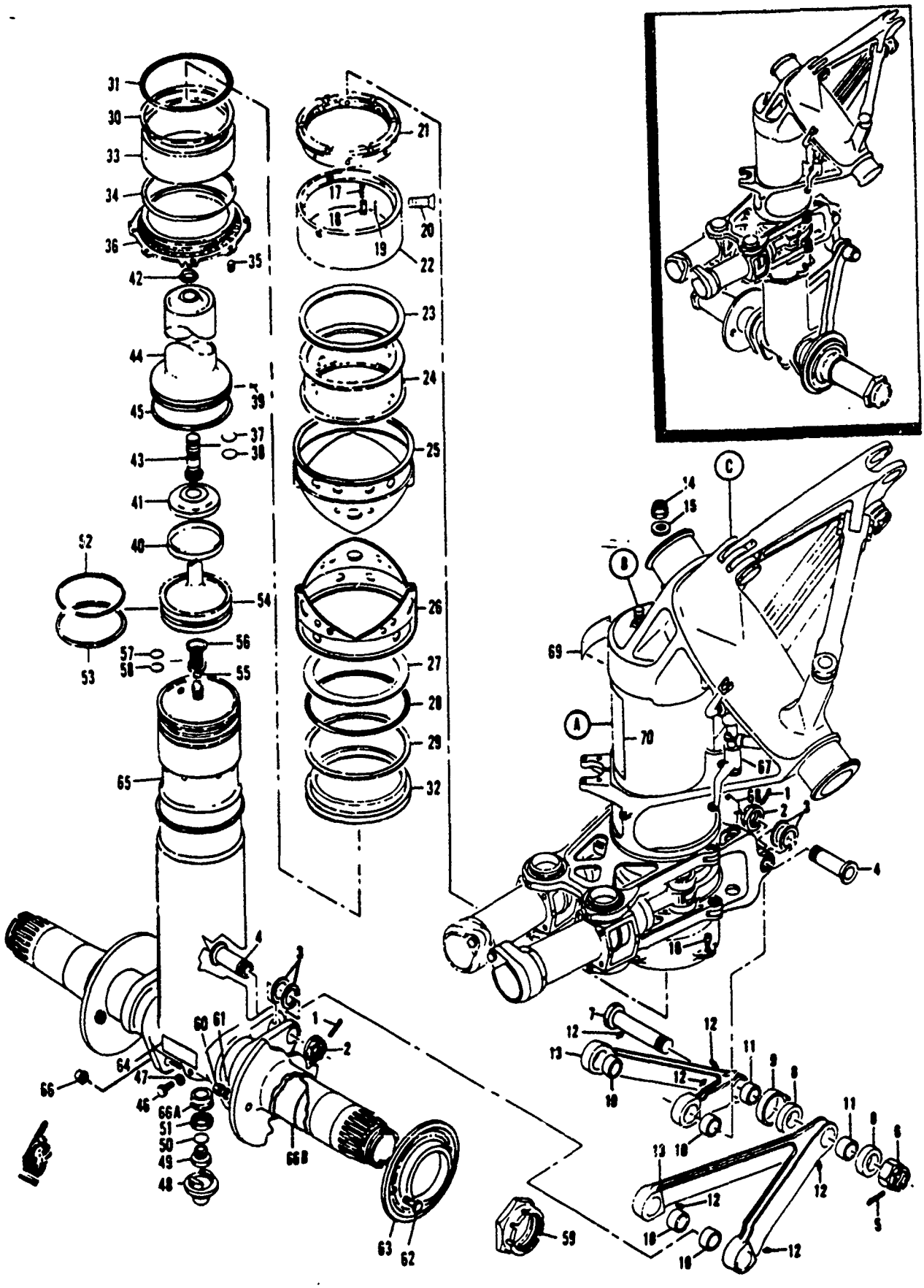


Figure 2-2. Main Landing Gear Strut Assembly (Sheet 2 of 4)

1. Pin
2. Nut
3. Washer
4. Bolt
5. Pin
6. Nut
7. Bolt
8. Bearing
9. Support
10. Bearing
11. Bearing
12. Fitting
13. Link
14. Nut
15. Washer
16. Pin
17. Pin
18. Nut
19. Washer
20. Bolt
21. Nut
22. Bearing
23. Shim
24. Spacer
25. Cam
26. Cam
27. Washer
28. Packing
29. Ring
30. Ring
31. Packing
32. Ring
33. Bearing
34. Scraper
35. Sleeve
36. Nut
37. Ring
38. Packing
39. Rivet
40. Nut
41. Plate
42. Nut
43. Bolt
44. Tube
45. Ring
46. Bolt
47. Washer
48. Cone
49. Plug
50. Gasket
51. Nut
52. Packing
53. Ring
54. Rod
55. Tube
56. Washer
57. Packing
58. Ring
59. Nut
60. Nut
61. Washer
62. Bolt
63. Collar
64. Metal-Cal
65. Cylinder
66. Bushing
66A. Insert
66B. Sleeve
67. Jackshaft Instl
68. Control Instl
69. Metalcal
70. Metalcal
71. Ring
72. Pin
73. Ring
74. Pin
75. Bolt
76. Washer
77. thru 86. Deleted
87. Fitting
88. Fitting
89. Fitting
90. Link Fitting
91. Plate
92. Nut
93. Washer
94. Screw
95. Rivet
96. Quadrant
97. Bearing Half
98. Bearing Half
99. Bearing Half
100. Bearing Half
101. Valve
102. Tube
103. Packing
104. Cap Half
105. Cap Half
106. Cap Half
107. Cap Half
108. Tube
108A. Packing, O-ring
108B. Ring Backup
109. Tube
109A. Packing O-ring
110. Tube
110A. Packing O-ring
111. Pin
112. Nut
113. Washer
114. Bolt
115. Bolt
116. Link
117. Pin
118. Nut
119. Washer
120. Bolt
121. Bolt
122. Nut
123. Bolt
124. Link
125. Link
126. Bushing
127. Bushing
128. Bushing
129. Bushing
130. Sleeve
131. Connector
132. Spacer
133. Bushing
134. Ring
135. Packing
136. Cylinder
137. Shipping Plate
138. Screw
139. Bushing
140. Bushing
141. Bushing
142. Bushing
143. Bushing
144. Holes
145. Hole
146. Hole
147. Hole
148. Holes
149. Holes
150. Holes
151. Holes

Figure 2-2. Main Landing Gear Strut Assembly (Sheet 1 of 4)

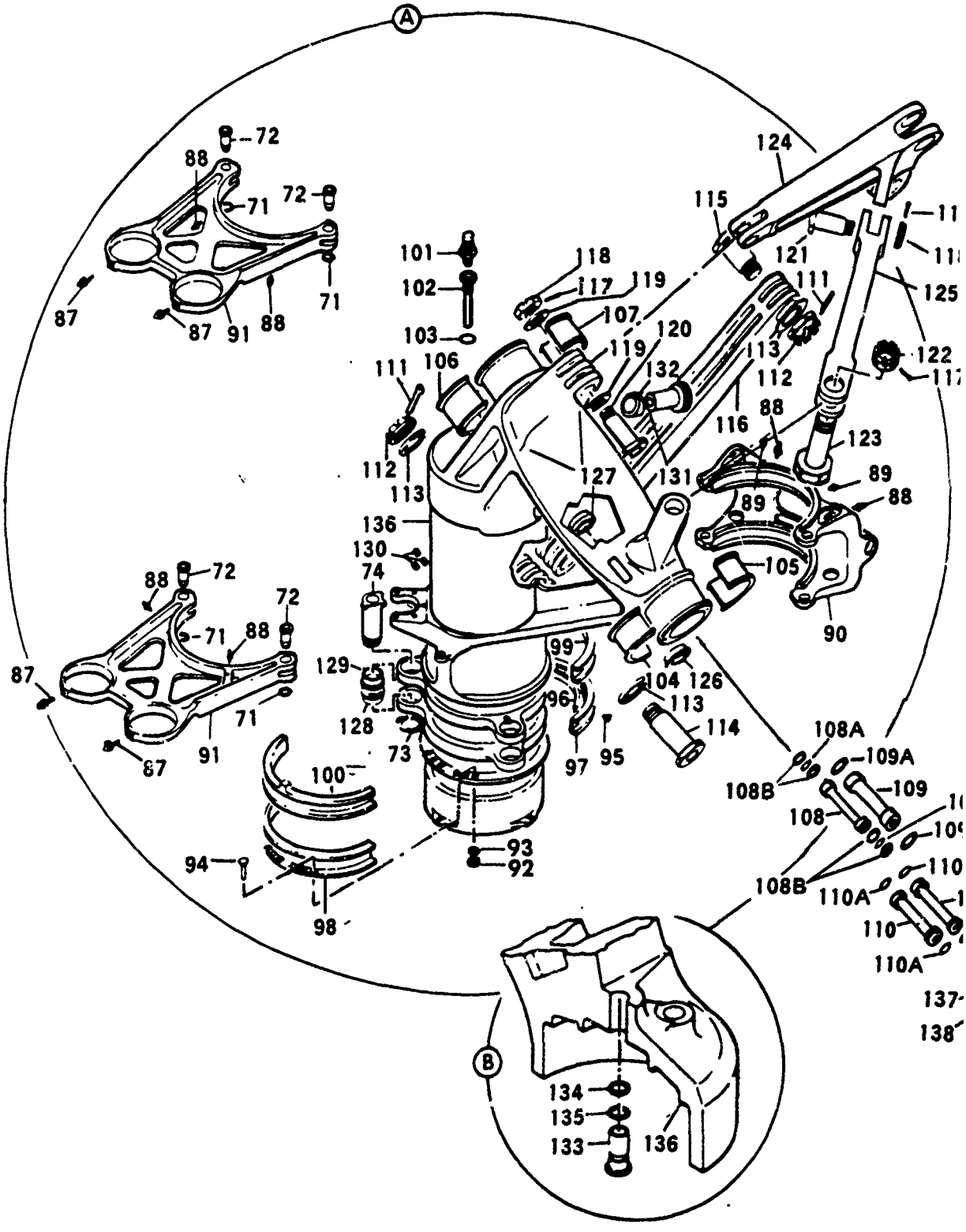


Figure 2-2. Main Landing Gear Strut Assembly (Sheet 3 of 4)

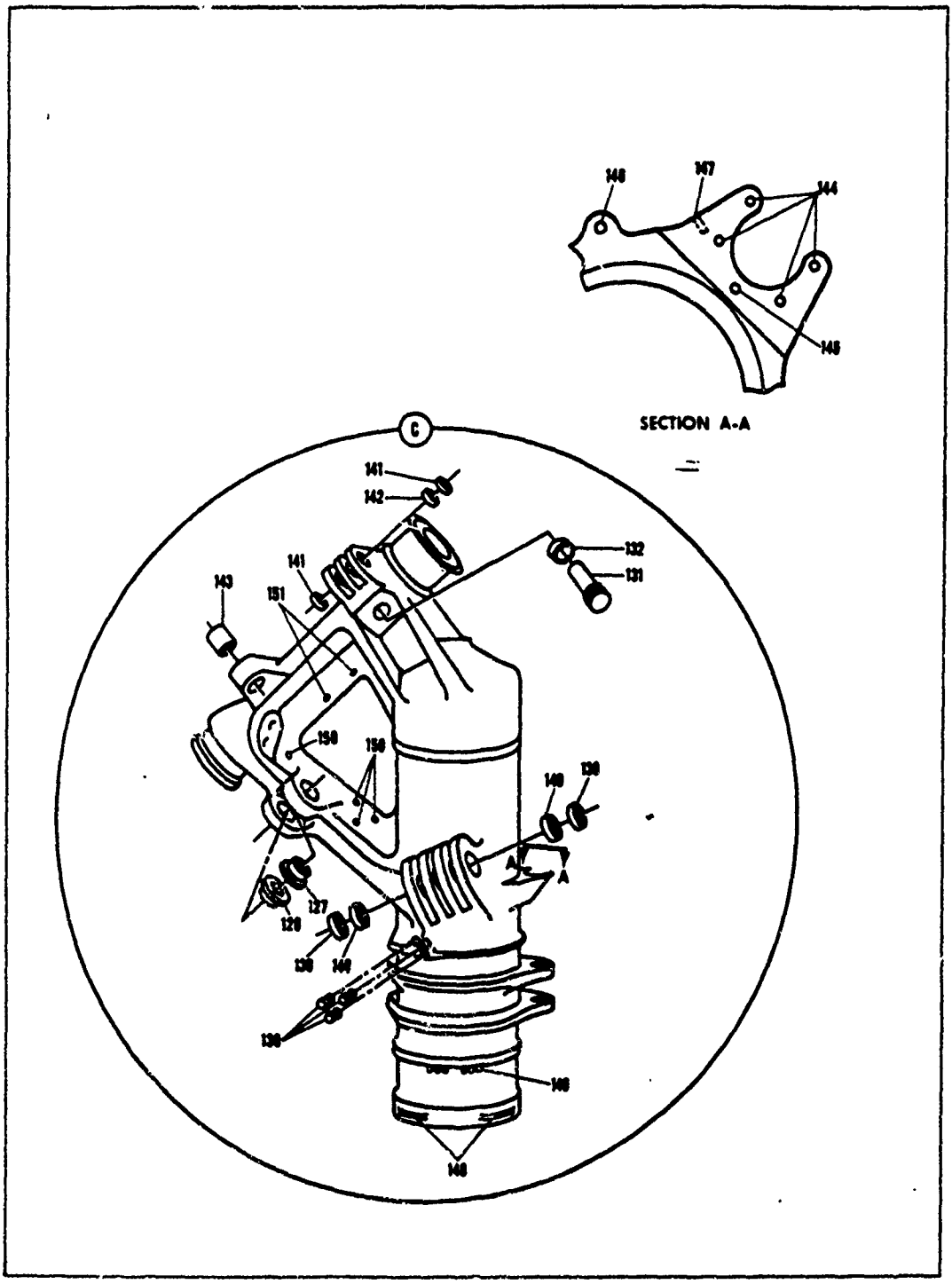


Figure 2-2. Main Landing Gear Strut Assembly (Sheet 4 of 4)

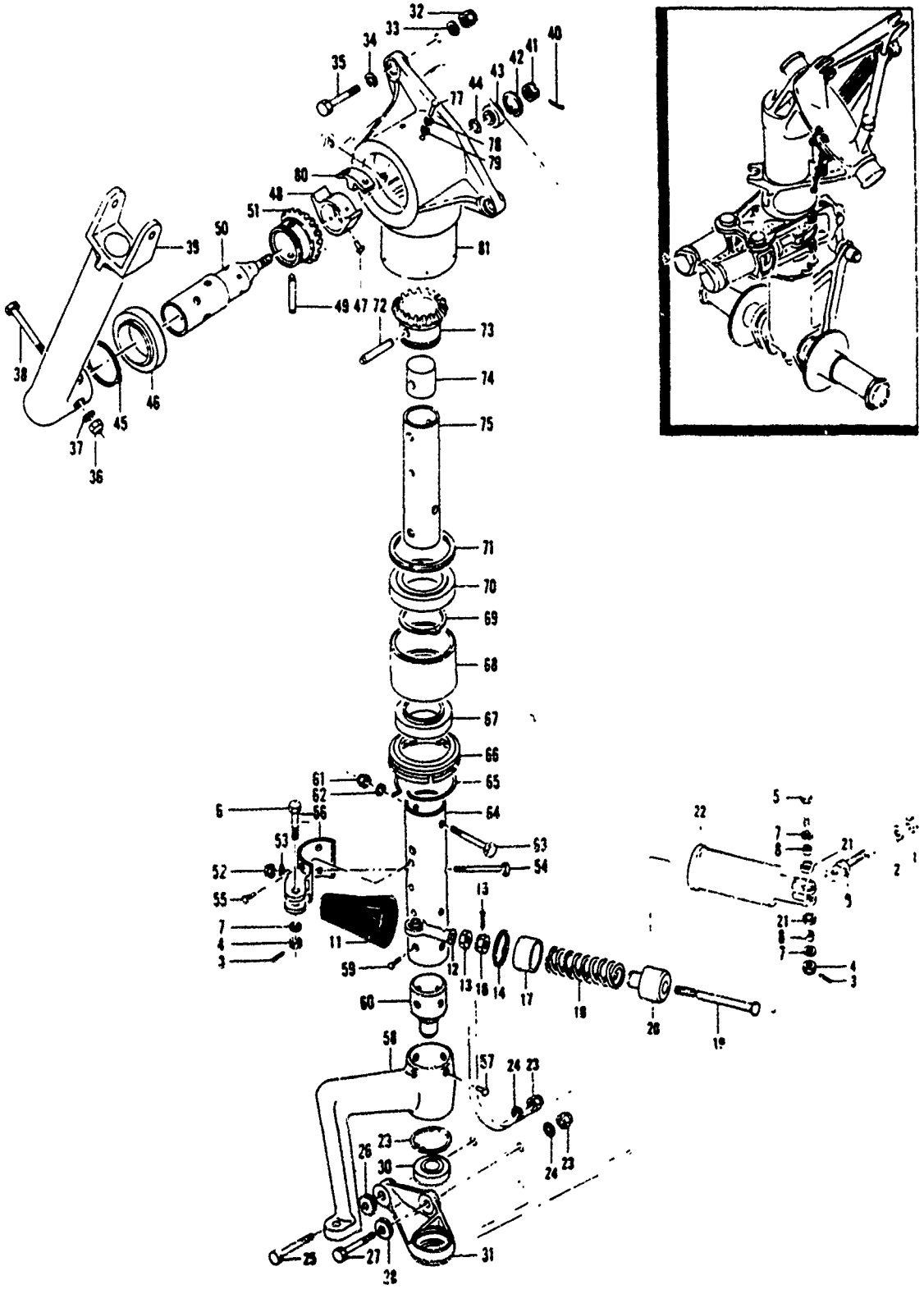


Figure 2-3. Landing Gear Steering Jackshaft Installation (Sheet 1 of 2)

1. Nut
2. Washer
3. Pin
4. Nut
5. Bolt
6. Bolt
7. Washer
8. Bushing
9. Bolt
10. Deleted
11. Boot
12. Bearing
13. Nut
14. Ring
15. Pin
16. Nut
17. Slide
18. Spring
19. Rod
20. Slide
21. Bushing
22. Housing
23. Nut
24. Washer
25. Bolt
26. Washer
27. Bolt
28. Washer
29. Ring
30. Bearing
31. Support
32. Nut
33. Washer
34. Washer
35. Bolt
36. Nut
37. Washer
38. Bolt
39. Arm
40. Pin
41. Nut
42. Ring
43. Bearing
44. Shim
45. Ring
46. Bearing
47. Rivet
48. Stop
49. Pin
50. Shaft
51. Gear
52. Nut
53. Washer
54. Bolt
55. Rivet
56. Arm
57. Rivet
58. Arm
59. Rivet
60. Adapter
61. Nut
62. Washer
63. Bolt
64. Tube
65. Ring
66. Nut
67. Bearing
68. Sleeve
69. Ring
70. Bearing
71. Shim
72. Pin
73. Gear
74. Plug
75. Shaft
76. Collar
77. Rivet
78. Washer
79. Washer
80. Stop
81. Housing

Figure 2-3 Landing Gear Steering Jackshaft Installation (Sheet 2 of 2)

1. Nut
2. Washer
3. Spacer
4. Pin
5. Nut
6. Bolt
7. Bolt
8. Terminal
9. Terminal
10. Nut
11. Nut
12. Turnbuckle
13. Gasket
14. Bolt
15. Bolt
16. Bolt
17. Washer
18. Washer
19. Screw
20. Washer
21. Gasket
22. Metal-Cal
23. Cover
24. Nut
25. Clamp
26. Nut
27. Washer
28. Screw
29. Nut
30. Washer
31. Washer
32. Screw
33. Terminal
34. Terminal
35. Connector
36. Spring
37. Spring
38. Screw
39. Washer
40. Bearing
41. Screw
42. Nut
43. Pin
44. Follower
45. Actuator
46. Nut
47. Washer
48. Arm
49. Pawl
50. Packing
51. Shaft
52. Nut
53. Screw
54. Washer
55. Insulator
56. Actuator
57. Switch
58. Screw
59. Washer
60. Insulator
61. Actuator
62. Switch
63. Nut
64. Washer
65. Post
66. Screw
67. Screw
68. Washer
69. Screw
70. Adapter
71. Rivet
72. Shaft
73. Transmitter
74. Screw
75. Washer
76. Cover
77. Bolt
78. Washer
79. Nut
80. Metal-Cal
81. Gasket
82. Ring
83. Key
84. Bearing
85. Cam
86. Gear
87. Spacer
88. Ring
89. Bearing
90. Bearing
91. Sleeve
92. Sleeve
93. Sleeve
94. Housing

Figure 2-4. Main Gear Position Control Installations (Sheet 1 of 2)

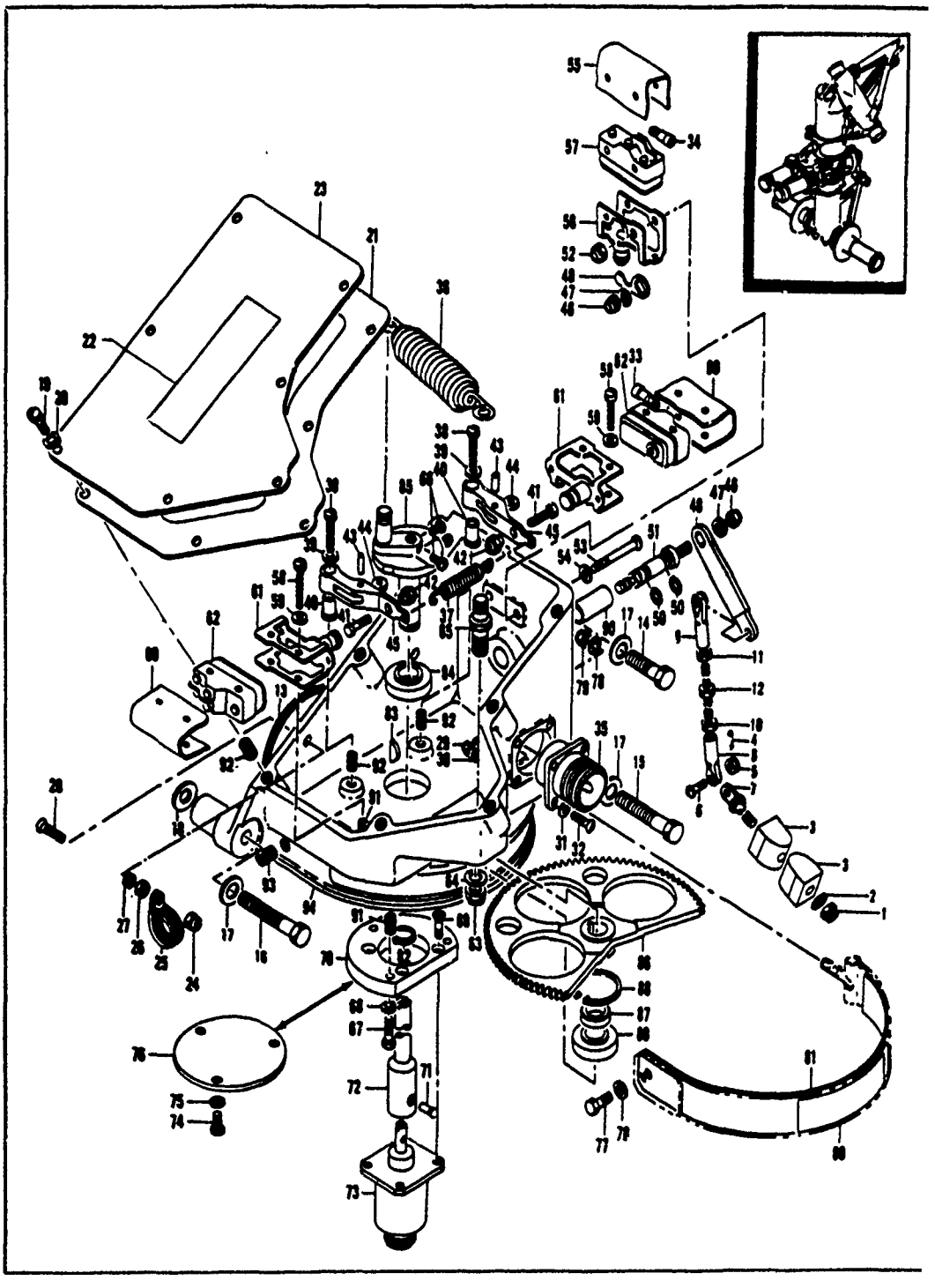


Figure 2-4. Main Gear Position Control Installations (Sheet 2 of 2)

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD [illegible] 09/28/89 A-ED46B-MM1-DY-M45 P

26337A F15 MLG R/H MW RCC MNP3F 4A4-22-3 36224

OPER SUB STEP	TECH T K L	S W K	F RF A/R REV A FA C DC	SUPPORT ELEMENT	DCC FACT	<---------- DESCRIPTION ----------> STORED	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS
0100	S	N	3S EA E	X 33204	1.00	PERCENT ENGR 72.6	STRUT ASSY F-15	1.16		1.16
0001			3S 01 00		.00		PART NUMBER /NEW	.000	.000	.000
0010						68A410501-2007	1620010360335			
0020						68A410501-2008	1620010360336			
0030						69A410501-2009	1620010672791			
0040						68A410501-2010	1620010799938			
0050						68A410501-2011	1620011671000			
0060						68A410501-2012	1620011670999			
0510			3S 01 25		1.00		PAINT MED STRUT ASSY	.582	.146	.729
0010	E		ZLG-HH-02		1.00	LOAD MED STRUT ON O/H CONV	LOAD OVERHEAD CRANE	.02068		.025
0020	E		ZMA-MA-41		1.00	MASK MED MLG STRUT FOR PAINT		.09313		.116
0030	E		ZMP-PP-P2		1.00	FINAL PAINT MED STRUT/PART		.25790		.322
0040	E		RLG-JP-DS		1.00	GET STRUT DECALS F/STO CAB		.00693		.008
0050	E		ZMP-UM-01		1.00	UNMASK SM STRUT NOSE OR MAIN		.14520		.181
0060	E		ZLG-HH-U1		1.00	UNLOAD OVERHEAD CONVEYOR		.03462		.043
0070	E		KID-DL-AA		1.00	INSTALL DECAL PR SENSITIVE		.01378		.017
0080	E		RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DCC		.01001		.012
0512			3S 01 2E		1.00		DECALS	.030	.002	.038
0010	E		RLG-JP-DS		1.00	GET STRUT DECALS F/STO CAB		.00693		.008
0020	E		KID-DL-AA		1.00	INSTALL DECAL PR SENSITIVE		.01378		.017
0030	E		RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DCC		.01001		.012
0520			3S 01 25		1.00		FINAL ACCEPTANCE OF W.S.I.	.180	.045	.225
0010	N				1.00		FINAL	.12900		.160
0020	E		GJF-FP-B5		1.00		FILL OUT FORM 424 & ATTACH	.05255		.065
0530			3S 01 25		1.00		FINAL VISUAL INSPECTION	.137	.034	.171
0010	N				1.00		FINAL VISUAL INSPECTION	.12700		.158
0020	E		RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DCC		.01001		.012
9000			3S 01 25		.01		LABOR STANDARD HISTORY	.000	.000	.000
0011						19MAR85 DOWN GRADED NOT MARKET BASKET				
0012						11MAR86 ADDED PREPAINT ADAPTOR OLD STD 1.60				
0900						J.CALDWELL TECH MANEAA				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PAD AROP NR
,---,----,---,
1C345678901E3456 ELSE PUT IN END

SECTION I
INTRODUCTION

1-1. IDENTIFICATION. (See figure 1-1.)

1-2. This technical manual contains overhaul and test instructions for Left Front Main Landing Gear Strut Assembly, Part No. 25-4200-1, manufactured by The Boeing Company, Wichita, Kansas.

1-3. PURPOSE AND LEADING PARTICULARS. (See figure 1-2.)

1-4. The major components of the left front main landing gear strut assembly are the outer cylinder assembly, inner cylinder assembly, steering actuator assemblies, jackshaft installation, torsion link assemblies, orifice rod assembly, centering cam assembly, and position control installation.

1-5. The torsion link assemblies, attached to the steering plate assembly, are rotated around the outer cylinder assembly by the steering actuator assemblies, and turn the axle attached to the inner cylinder assembly. The inner cylinder assembly turns on a compressed air bearing within the st assembly. The orifice rod restricts flow of hyd oil to eliminate rapid extension and retraction the strut assembly caused by aircraft bounce, t providing shock absorption. The upper and lo centering cams center the wheels when the stru extended. The jackshaft installation transmits control from remote sources. The position cont installation contains centering switches that ar operated by a cam geared to the outer cylinde assembly, and a safety switch.

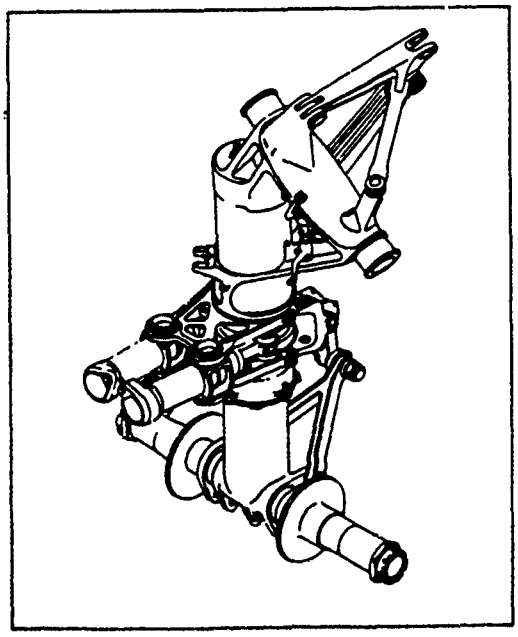


Figure 1-1. Main Landing Gear Strut Assembly

Type	Telescopic oleo shock str
Oil Capacity	5 US gal (a
Stroke*	
Extended	55.5
Static	40.0
Compressed	37.5
Operating Pressures	
Extended	506
Taxi	2118
Compressed	4251
Temperature Range	-54° C (-65° F 71° C (160°
Weight	903

*Measured vertically from center point of inbo trunnion to axle centerline.

Figure 1-2. Table of Leading Particulars

1-6. CONTENTS.

1-7. Sections I, II, and III of this manual con overhaul and test instructions for Left Front Ma

FAMILY 6

CONTROL NUMBER LIST

LABO TECH	PLAN TECH	CONTROL NUMBER	JOP DESC	AIRCRAFT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TECHDI
COOP	COOP	16283A		C-141 MLG	DRAG BRACE SHAFT	1620-00-785-6073	3611500-101	4S1-73-3
MONR	COOP	16296A	-G	H-3 MLG	STRUT ASSY	1620-00-482-1247	S6127-50102-4	4S1-72-3
MONR	COOP	16297A	-G	CH-3 MLG	STRUT ASSY	1620-01-037-4639	S6127-50501-4	4S2-50-3
JENS	RIGB	16298A		F-15 C & D	BRAKE HOUSING	1630-01-065-9469	2606006	4B1-2-11
MONR	ANDE	16301A	-G	F-4 MLG	STRUT ASSY R/H DRY	1620-00-919-6846	53-41400-302	4S1-71-3
MONR	ANDE	16302A	-G	F-4 MLG	STRUT ASSY L/H DRY	1620-00-919-6847	53-41400-301	4S1-71-3
COOP	COOP	16315A		F-16 MLG	AXLE L/H	1620-01-071-0535	2006035-103	4S1-109-
MART	SHEL	16328A		F-15	DRUM ASSY	1005-01-042-9748	205F481	11W1-7-1
MART	SHEL	16331A			ENTRANCE UNIT ASSY	1005-00-397-7834	189F322	11W1-29-
COOP	COOP	16334A		F-16 MLG	AXLE R/H	1620-01-071-0537	2006035-104	4S1-109-
DELE		16352A		C-7 MLG	HOUSING	1620-01-020-8650	17 OCT 88	4S1-81-3
JENS	PRIC	16404A	-J	C-130 MLG	WHEEL (NAVY)	1630-01-014-0656	4B	NAVAIR 0
DELE		16409A	-J	C-130 MLG	BRAKE ASSY (NAVY)	1630-00-052-8403	9550402	4B1-2-13
DELE		16411A	-J	C-130 MLG	BRAKE ASSY (NAVY)	1630-00-875-4866LC	9541667	4B1-2-13
COOP	COOP	16582A		F-16 MLG	TORQUE ARM-LOWER	1620-01-071-5592	2006629-105	4S2-80-3
MART	SHEL	16613A		F-16	AIM ADAPTER ASSY	1440-01-050-9264AB	16S301-817	11LA8-9-
MART	SHEL	16614A		F-15	UNLOAD DRIVE ASSY	1005-00-188-6969	176F727	11W1-1-1
MART	SHEL	16615A		F-106	DRUM ASSY	1005-00-397-7835	189F336	11W1-29-
COOP	COOP	16623A		C-141 MLG	TORQUE ARM	1620-01-114-6869	3610007-117	4S1-73-3
MART	SHEL	16705A		F-15	LAU 114 LAUNCHER	1440-01-114-9506AB	68A732501-1009	11W1-2-1
COOP	COOP	16727A		F-16 MLG	TORQUE ARM-UPPER	1620-01-124-9137	2006629-111	4S2-80-3
COOP	RIGB	16734A	-J	F-111 MLG	TORQUE PLATE	1630-00-468-1727	4-52	4B1-2-48
COOP	POLL	16743A		C-141 MLG	DOWN LOCK BELLCRANK	1620-00-284-1208	3661100-101	4S2-59-3
COOP	COOP	16744A		F-111 MLG	PIN AXLE	1620-00-084-6844	12L594-7	4A4-1-11
JENS	RIGB	16776A	-J	A-37 MLG	BRAKE ASSY	1630-00-847-3731	9550404	4B1-2-10
JENS	COOP	16777A		C-7A MLG	DRAG BRACE	1620-00-066-2768	5750-15	4S1-82-3
MONR	ANDE	16836A	-G	F-4 MLG	STRUT ASSY R/H WET	1620-00-109-9286	53-41500-1	4S1-71-3
MONR	ANDE	16837A	-G-J	F-4 MLG	STRUT ASSY L/H WET	1620-00-109-9287	53-41500-2	4S1-71-3
JENS	COOP	16915A		KC-135 MLG	TRUCK ASSY	1620-00-948-5866	1583-166A	4A4-12-2
COOP	COOP	17142A	-G-J	B-52 MLG	STRUT ASSY H/W	4620-00-139-8473	7027648-198-150	4S1-57-3
COOP	COOP	17143A	-G-J	B-52 MLG	STRUT ASSY H/W	1620-00-139-8474	7027648-218-170	4S1-57-3
JENS	COOP	17224A	-J	C-7 MLG	HOUSING	1620-00-483-8443	69F27216-02	4S1-81-3
JENS	COOP	17239A	-G-J	KC-135 MLG	TRUNNION	1620-00-679-3440	50-9717-22	4A4-12-2
BENT	COOP	17245A	-G-J	KC-135 MLG	DRAG BRACE	1620-00-652-5472	50-9733-1	4A4-12-2
BENT	COOP	17313A	-G-J	KC-135 MLG	TRUNNION	1620-00-651-8222	50-9717-4	4A4-12-2
BENT	COOP	17314A	-G-J	KC-135 MLG	UPPER SIDE STRUT	1620-00-306-9942	5-84011-1	4A4-12-2
BENT	COOP	17315A	-G-J	KC-135 MLG	UPPER SIDE BRACE	1620-00-306-9943	5-84011-3	4A4-12-2
COOP	TOLM	17324A	-G	F-111 MLG	STRUT ASSY-SHOCK	1620-00-300-2261	7327080-50	4S1-78-3
BENT	COOP	17327A	-G-J	KC-135 MLG	TRUNNION	1620-00-911-8301	50-9717-25	4A4-12-2
COOP	TOLM	17346A	-G	F-111 MLG	AXLE	1620-00-139-3651	12L10021-804	4A4-17-3
BENT	COOP	17347A	-G-J	KC-135 MLG	UPPER SIDE STRUT	1620-00-709-9371	5-84011-1	4A4-12-2
BENT	COOP	17348A	-G-J	KC-135 MLG	UPPER SIDE STRUT	1620-00-711-7771	5-84011-28	4A4-12-2
COOP	COOP	17353A	-G	F-111 MLG	STRUT ASSY	1620-00-545-9395	7430562-14	4A4-18-3
COOP	TOLM	17354A	-G	F-111 MLG	STRUT ASSY	1620-00-545-9439	7430564-10	4A4-14-3
BENT	COOP	17357A	-G-J	KC-135 MLG	BRACE ASSY	M 1620-00-741-9178	65-4829-3	4SA6-5-3
COOP	COOP	17402A	-G-J	F-15 MLG	STRUT ASSY	M 1620-01-062-7002	68A450600-1013	4S2-73-3
BENT	COOP	17407A	-G-J	KC-135 MLG	BOLT TRUNNION	1620-00-992-1498	69-10852-2	4A4-12-2
COOP	TOLM	17418A	-G	F-111 MLG	STRUT ASSY-SHOCK	1620-01-013-5910	7327074-90	4S1-78-3
BENT	COOP	17451A	-G-J	KC-135 MLG	TRUNNION	M 1620-00-651-8221	50-9717-3	4A4-12-2
COOP	TOLM	17461A	-G-J	F-106 MLG	STRUT ASSY	1620-00-592-9638	578100-505	4S1-32-2

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTOR STAND HOURS
17143A	MKPRW	XKPRW	X	4N	5	.30	1.00	
FAMILY 6 B-52 MLG	*							
	MNPGP	00010	N	HB	5	10.72	1.00	10.
		P0017	E	HB	5	4.28	1.00	4.
		P0002	E	3S	5	.54	1.00	
		P0003	E	3S	5	3.08	1.00	3.
		PS004	E	HB	5	.28	1.00	
		PS021	N	HB	5	.30	1.00	
	*							19.
	MNPGW	PM003	E	DJ	5	1.22	1.00	1.
		WC001	E	KI	5	2.61	1.00	2.
		WD001	E	HB	5	4.74	1.00	4.
		WE001	E	DI	5	1.65	1.00	1.
		WE002	E	DI	5	1.15	1.00	1.
		WE004	N	DI	5	.37	1.00	
		WE005	N	DI	5	.27	1.00	
		WE006	N	DI	5	.33	1.00	
		WE007	N	DI	5	.30	1.00	
		WE008	N	DI	5	.55	1.00	
		WE009	N	DI	5	.27	1.00	
		WE010	N	DI	5	.23	1.00	
		WE013	N	DI	5	.13	2.00	
		WE014	N	DI	5	.12	1.00	
		XNPGW	X	HB	5	5.93	1.00	5.
	*							20.
	MNPMG	XNPMG	X	JB	1	.20	1.00	
	*							
	MNPNA	NA001	E	DB	2	.19	.10	
		NA002	E	DB	2	.88	1.00	
		NA005	E	DB	2	.23	1.00	
		NA006	E	DB	2	.23	1.00	
		NA007	E	DB	2	.10	1.00	
		NA008	E	DB	2	2.06	1.00	2.
		NA009	E	DB	2	.46	.55	
		NA010	E	DB	2	.10	.96	
		NA013	E	DB	2	.20	.15	
		NA014	E	DB	2	.20	.54	
		XNPNA	X	DB	2	4.91	1.00	4.
	*							8.
	MNPRA	RA001	E	JA	1	16.27	.59	9.
		RA002	E	JA	1	4.44	.83	3.
		RA004	E	JA	1	.86	.63	
		RA005	E	JA	1	3.94	1.00	3.

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTOR STAND HOURS
17143A	MNPRA	RA006	E	JA	1	5.25	1.00	8.
		RA007	E	JA	1	3.20	.96	3.
		RA008	E	JA	1	5.51	1.00	6.
		RA009	E	JA	1	1.28	.08	
		RA010	N	JA	1	.45	1.00	
		RA014	E	JA	1	3.79	.13	
		RA021	E	JA	1	.45	.10	
	*							41.
	MNPRB	RB001	N	JA	3	3.48	.08	
		RB002	E	JA	3	19.83	.46	8.
		XNPRB	X	JA	3	2.15	1.00	2.
	*							11.
	MNPRC	RC001	E	UP	8	3.09	.83	2.
		RC002	E	UP	8	6.92	.92	6.
		RC004	E	UP	8	.54	1.63	
		RC005	E	UP	8	.64	.96	
		RC006	E	UP	8	.64	1.00	
		RC007	E	UP	8	.76	.92	
		RC008	N	UP	8	13.96	.63	5.
		RC009	E	UP	8	1.69	1.75	2.
		RC010	E	UP	8	1.53	.42	
		RC013	E	UP	8	.64	2.00	1.
		RC014	E	UP	8	.68	.54	
		XNPRC	X	UP	3	4.79	1.00	4.
	*							30.5
	MNPWW	WF001	N	WF	9	16.00	.05	8
		WH003		WF	A	.11	.96	
	*							9
*								133.0

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B-52H AFT

BILL OF MATERIALS

17143A

* = MMI

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	10	7027648-210	1620001398474	98747	B-52 MAIN STRUT ASSY AFT	1	EA										
STL	.1	4-60728	5310011086201LE	81205	.NUT, SPECIAL	4	EA										
BRASS	.1	4-60729	5310011122452LE	81205	.WASHER, SPECIAL	8	EA										
STL	.1	4-60726	5306003025639FG	81205	.BOLT, SPECIAL	4	EA										
STL	.1	4-60727	5306006122883	81205	.BOLT, SPECIAL	1	EA										
STL	.1	T127KP	3110001170759	60038	.BEARING, TAPERED ROLLER	2	EA										
STL	.1	BACB10C41KP	N.S.L.		.BEARING, TAPERED ROLLER	2						INT					
SYN	.1	4-60773	1620000254819	81205	.SUPPORT, BRAKE LINE	1	EA										
	.1	1-60721-1	1620003170530	81205	.LINK ASSY, TORSION	2	EA										
STL	..2	GB2824POH	3110002710063LE	60380	..BEARING, SINGLE ROW NEEDLE (KIT)	2	EA										
	..2	MS15001-2	4730001720001	96906	..FITTING, LUB (KIT)	3	EA										
	..2	N.P.L.	N.S.L.		..LINK SUBASSY, TORSION	1											
	...3	1-60722	N.S.L.		...LINK, TORSION	1											
STL	...3	4-60724-1	3120006624712LE	81205	...BEARING, TORSION LINK	1	EA										
STL	.1	6-65745	5315010799330LE	81205	.PIN, OLEO RETAINER NUT	4	EA										
	.1	MS24665-283	5315008423044	96906	.PIN, COTTER	3	EA										
	.1	3-60736-3	5310006035970LE	81205	.NUT, RETAINER, UPPER OLEO BEARING	1	EA										
SYN	.1	3-60735-2	1620006046327	82918	.BEARING, UPPER OLEO	1	EA										
SS	.1	6-63704-501	5365002748869LE	81205	.SHIM, LAMINATED	1	AR EA										
AL	.1	3-60734	5365003452195LE	81205	.SPACER, UPPER CAM	1	EA										
	.1	25-4214-501	1620007330993	81205	.CAM ASSY, MAIN LANDING GEAR	1	EA										
	..2	25-4213	N.S.L.	81205	..CAM UPPER	1											
	..2	25-4212	N.S.L.	81205	..CAM LOWER	1											
AL	.1	3-60741	5365011440621LE	81205	.WASHER, SPECIAL	1	EA										
AL	.1	3-60742	5330003330641LE	81205	.RING, ADAPTER	1	EA										
SYN	.1	6-65746-1	3120005407523LE	81205	.BEARING, LOWER OLEO	1	EA										
BRASS	.1	MS28776-62	N.S.L.		.SCRAPER	1											
BRASS	.1	MS28776M2-62	1650008645238	96906	.SCRAPER	1	EA					SUB					
AL	.1	25-4209	5310006097227LE	82918	.NUT ASSY, LOWER BEARING	1	EA										
AL	..2	25-4209-1	N.S.L.		..NUT GLAND, ALUM	1											
	..2	1191-4CN3-8	N.S.L.	91767	..SLEEVE, HELICOIL	8											
STL	.1	5-69169	N.S.L.		.NUT GLAND, STEEL	1						INT					
AL	.1	25-4217	1620006099887	82918	.TUBE ASSY	1	EA										
	..2	MS20470AA-12	5320006190842	96906	..RIVET	2	EA										
	..2	26-2642	5365009271866	81205	..NUT, ORIFICE PLATE RETAINING	1	EA										
	..2	26-2640	N.S.L.		..PLATE, ORIFICE	1											
	..2	23-1950	N.S.L.		..NUT, PISTON TUBE RETAINER	1											
	..2	26-2643	5306006028638FG	82918	..BOLT, PISTON TUBE RETAINER	1	EA										

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ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	..2	23-1951-1300	5310006745213LE	82918	..WASHER, DRAIN TUBE LOCK (KIT)	1	EA										
	..2	MS28775-214	5330005793163	96906	..PACKING, O-RING (KIT)	1	EA										
	..2	MS28774-214	5330005437089	96906	..RING, BACKUP (KIT)	1	EA										
STL	.1	11-80951	N.S.L.		.ROD ASSY, REAR ORIFICE	1						INT					
STL	.1	11-80951-2	1162000964428	81205	.ROD ASSY, REAR ORIFICE	1	EA					INT					
STL	.1	MS21025-71	5310008440043	96906	.NUT, AXLE (WITH "X" STAMPED)	2	EA										
	.1	BACN10BY54W	5310006807504	81205	.NUT, SELF LOCKING	4	EA										
	.1	AN4-7A	5306005158064	88044	.BOLT, MACHINE	4	EA										
AL	.1	5-71612	5365006963054LE	81205	.COLLAR, AXLE	2	EA										
	.1	BACN10663-1CC	N.S.L.	LOC MFG	.METAL-CAL	1											
	.1	5-85123-6	1162000682588	81205	.CYLINDER ASSY	1	EA										
	..2	36-7090-1	1162000964288	82918	..INSERT, AXLE	1	EA										
	..2	N.P.L.	N.S.L.		..CYLINDER SUBASSY	1											
	...3	66C33000-03S01	3120009898163	98747	...BUSHING, TOW LUG (RPR)	2	AR EA										
	...3	16-71444	3120009490418LE	81205	...BUSHING, TOW LUG (RPR)	2	AR EA					ALT					
	...3	68C29160-25	3120001040181LE	98747	...BUSHING, TORQUE ARM (RPR)	4	AR EA										
	...3	N.P.L.	N.S.L.		...CYLINDER	1											
	.1	23-4204	1162000625469	82918	.CYLINDER ASSY	1	EA					INT					
	..2	36-7090-1	1162000964288	82918	..INSERT AXLE	1	EA										
	..2	N.P.L.	N.S.L.		..CYLINDER SUBASSY	1											
	...3	66C33000-03B01	3120009898163	98747	...BUSHING, TOW LUG (RPR)	2	AR EA										
	...3	16-71444	3120009490418LE	81205	...BUSHING, TOW LUG (RPR)	2	AR EA					ALT					
	...3	68C29160-25	3120001040191LE	98747	...BUSHING, TORQUE ARM (RPR)	4	AR EA										
	...3	N.P.L.	N.S.L.		...CYLINDER	1											
	.1	23-4204-1	1162000838023	86276	.CYLINDER ASSY	1	EA					INT					
	..2	36-7090-1	1162000964288	82918	..INSERT AXLE	1	EA										
	..2	N.P.L.	N.S.L.		..CYLINDER SUBASSY	1											
	...3	66C33000-03S01	3120009898163	98747	...BUSHING, TOW LUG (RPR)	2	AR EA										
	...3	16-71444	3120009490418LE	81205	...BUSHING, TOW LUG (RPR)	2	AR EA					ALT					
	...3	68C29160-25	3120001040181LE	98747	...BUSHING, TORQUE ARM (RPR)	4	AR EA										
	...3	N.P.L.	N.S.L.		...CYLINDER	1											
	.1	23-4204-4	N.S.L.		.CYLINDER ASSY	1						INT					
	..2	36-7090-1	1162000964288	82918	..INSERT AXLE	1	EA										
	..2	N.P.L.	N.S.L.		..CYLINDER SUBASSY	1											
	...3	66C33000-03S01	3120009898163	98747	...BUSHING, TOW LUG (RPR)	2	AR EA										
	...3	16-71444	3120009490418LE	81205	...BUSHING, TOW LUG (RPR)	2	AR EA					ALT					
	...3	68C29160-25	3120001040181LE	98747	...BUSHING, TORQUE ARM (RPR)	4	AR EA										
	...3	N.P.L.	N.S.L.		...CYLINDER	1											

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171 A

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ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE (P,D,C)	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNB NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	1	15-68457-5	1620006052768	81205	.PLATE ASSY, STEERING	1	EA										
	1..2	MS15001-1	4730000504203	96906	..FITTING, LUB (KIT)	4	EA										
	1..2	MS15001-3	4730000504205	96906	..FITTING, LUB (KIT)	6	EA										
	1..2	MS15001-2	4730001720001	99999	..FITTING, LUB	2	EA										
	1..2	N.P.L.	N.S.L.		..TORSION LINK ASSY	1											
	1...3	68C29160-23	3120000113189LE	98747	...BUSHING,MOUNTING HOLES(O.S.)(RPR)	4	AR	EA									
	1...3	68C29160-25	3120001040181LE	98747	...BUSHING,TORQUE ARM LUG(O.S.)(RPR)	4	AR	EA									
	1...3	15-68456-1	N.S.L.	81205	...TORSION LINK	1											
	1..2	N.P.L.	N.S.L.		..PLATE, STEERING ASSY	2											
	1...3	68C29160-21	3120000113190LE	98747	...BUSHING,MOUNTING HOLES(O.S.)(RPR)	4	AR	EA									
	1...3	15-68455-2	N.S.L.	81205	...PLATE, STEERING	1											
	1	19-52532-501	1620009072897	81205	.BEARING ASSY, STEERING (LOWER)	1	EA										
	1..2	19-52299-504	1620009665425	81205	..BEARING SUB ASSY	1	EA										
	1...3	19-52299-10	N.S.L.		...BEARING, SETS (OLD)	1											
	1...3	19-52299-501	N.S.L.		...BEARING, SETS (NEW)	1						INT					
	1..2	MS20426DD5-6	5320001177214	96906	..RIVET	2	EA										
	1..2	MS2042605-6	N.S.L.		..RIVET	2						INT					
	1..2	19-52273	1620006979554	81205	..GEAR QUADRANT	1	EA										
	1	19-52299-505	1620009665426	81205	.BEARING ASSY, STEERING (UPPER)	1	EA										
	1..2	19-52299-11	N.S.L.		..BEARING SETS (OLD)	1											
	1	MS28889-1	4820005356483	96906	.VALVE, CHARGING	1	EA										
STL	1	29-5203	1620006140870	82918	.TUBE, FILLER	1	EA										
	1	19-52976	1620003270505	81205	.CAP ASSY I.B.	1	EA										
	1..2	19-52976-1	N.S.L.	81205	..CAP HALF I.B.	1											
	1..2	19-52976-2	N.S.L.	81205	..CAP HALF I.B.	1											
	1	19-52977	1620003270506	81205	.CAP ASSY O.B.	1	EA										
	1..2	19-52977-1	N.S.L.	81205	..CAP HALF O.B.	1											
	1..2	19-52977-2	N.S.L.	81205	..CAP HALF O.B.	1											
AL	1	13-93828	1620003419382	81205	.TUBE, STEER PRES TRANSFER	1	EA										
AL	1	1007	N.S.L.	LOC MFG	.TUBE, TRANSFER(2024, T4 ALUM)(O.S.)	1	AR					ALT		*			
	1	MS28775-111	5330005798108	96906	.PACKING, O-RING	2	EA										
	1	MS28774-111	5330001636566	96906	.RING, BACKUP	4	EA										
AL	1	13-87966	1620002174997	81205	.TUBE, STEER RETURN TRANSFER	1	EA										
AL	1	1008	N.S.L.	LOC MFG	.TUBE, TRANSFER(2024, T4 ALUM)(O.S.)	1	AR					ALT		*			
	1	MS28775-114	5330006180801	96906	.PACKING, O-RING	2	EA										
AL	1	13-87958	1620002174995	81205	.TUBE, BRAKE PRESSURE TRANSFER	2	EA										
AL	1	1009	N.S.L.	LOC MFG	.TUBE, TRANSFER(2024, T4 ALUM)(O.S.)	2	AR					ALT		*			
	1	MS28775-110	5330005856663	96906	.PACKING, O-RING	4	EA										

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ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
STL	1.1	16-35161-1	5306002080665FG	81205	.BOLT, INBOARD TRIPOD LINK	1	EA										
	1.1	AN320-20	5310001768118	88044	.NUT, CASTLE	1	EA										
STL	1.1	16-68174	5306002972568FG	81205	.BOLT, INBOARD TRIPOD LINK	1	EA										
	1.1	N.P.L.	N.S.L.		.LINK ASSY, DRAG STRUT O/BD TRIPOD	1											
	1..2	68C29160-01	3120000113170LE	98747	..BUSHING, OUTBOARD LINK (RPR)	2	AR	EA									
	1..2	68C29160-15	3120000113241LE	98747	..BUSHING, OUTBOARD LINK (RPR)	2	AR	EA				INT					
	1..2	68C29160-03	3120000113171LE	98747	..BUSHING, OUTBOARD LINK (RPR)	2	AR	EA									
	1..2	68C29160-05	3120000113257LE	98747	..BUSHING, OUTBOARD LINK (RPR)	2	AR	EA									
	1..2	68C29160-27	3120003293862LE	98747	..BUSHING, OUTBOARD LINK (RPR)	2	AR	EA									
	1..2	15-36035-3	1620006207642	81205	..LINK, DRAG STRUT O/BD TRIPOD	1		EA									
	1..2	15-36035-2	N.S.L.	81205	..LINK, DRAG STRUT O/BD TRIPOD	1						INT					
	1.1	N.P.L.	N.S.L.		.LINK ASSY, DRAG STRUT I/BD TRIPOD	1											
	1..2	68C29160-09	3120004312719LE	98747	..BUSHING, INBOARD LINK (RPR)	4	AR	EA									
	1..2	68C29160-11	3120000113182LE	98747	..BUSHING, INBOARD LINK (RPR)	4	AR	EA									
	1..2	15-35964-3	1620000922837	81205	..LINK DRAG STRUT I/BD TRIPOD	1		EA									
	1.1	17027516-10	1620002421514	81205	.CYLINDER ASSY, MAIN OUTER	1		EA									
AL	1..2	39-23085-1	5935004584898	81205	..CONNECTOR ASSY	1		EA									
AL	1...3	39-23085-2	N.S.L.	81205	...CONNECTOR ELECT	1											
AL	1...3	39-23085-3	N.S.L.	81205	...SPACER CONNECTOR	1											
	1..2	N.P.L.	N.S.L.		..CYLINDER SUBASSY, OUTER	1											
	1...3	16-35130-501	3120009488153	82918	...BUSHING, STEERING LUG	2		EA									
	1...3	39-21477-7	3120009135556LE	81205	...BUSHING, STEERING LUG (1ST RPR)	2	AR	EA				ALT					
	1...3	39-21477-8	3120009135564LE	81205	...BUSHING, STEERING LUG (2ND RPR)	2	AR	EA				ALT					
	1...3	39-21477-9	3120009135561LE	81205	...BUSHING, STEERING LUG (3RD RPR)	2	AR	EA				ALT					
	1...3	166C33000-59R	N.S.L.		...BUSHING, STEERING LUG (4TH RPR)	2	AR					ALT					
	1...3	16-35130-502	3120009490420	82918	...BUSHING, STEERING LUG	2		EA									
	1...3	39-21477-10	3120009135563LE	81205	...BUSHING, STEERING LUG (1ST RPR).	2	AR	EA				ALT					
	1...3	39-21477-11	3120009135558LE	81205	...BUSHING, STEERING LUG (2ND RPR)	2	AR	EA				ALT					
	1...3	39-21477-12	3120009135559LE	81205	...BUSHING, STEERING LUG (3RD RPR)	2	AR	EA				ALT					
	1...3	166C33000-59S	N.S.L.		...BUSHING, STEERING LUG (4TH RPR)	2	AR					ALT					
	1...3	13-31572-501	3120009547993	82918	...BUSHING, ACTUATOR O.B.	1		EA									
	1...3	39-21477-1	3120009141335LE	82918	...BUSHING, ACTUATOR O.B. (1ST RPR)	1	AR	EA				ALT					
	1...3	39-21477-2	3120009135560LE	82918	...BUSHING, ACTUATOR O.B. (2ND RPR)	1	AR	EA				ALT					
	1...3	39-21477-3	3120009135553LE	82918	...BUSHING, ACTUATOR O.B. (3RD RPR)	1	AR	EA				ALT					
	1...3	166C33000-61S	3120010803830	98747	...BUSHING, ACTUATOR O.B. (4TH RPR)	1	AR	EA				ALT					
	1...3	13-31571-501	3120009522585	81205	...BUSHING, ACTUATOR I.B.	1		EA									
	1...3	39-21477-4	3120009135552LE	82918	...BUSHING, ACTUATOR I.B. (1ST RPR)	1	AR	EA				ALT					
	1...3	39-21477-5	3120009135554LE	82918	...BUSHING, ACTUATOR I.B. (2ND RPR)	1	AR	EA				ALT					
	1...3	39-21477-6	3120009135555LE	82918	...BUSHING, ACTUATOR I.B. (3RD RPR)	1	AR	EA				ALT					

STL=STEEL
AL=ALUMINUM
MAG=MAGNESIUM
TITA=TITANIUM
SS=S STEEL
SYN=SYNTHETIC
LD=LEAD

B-52M AFT

BILL OF MATERIALS

1713A

* = MMI

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	...3	35-24491-18	3120009136288LE	81205	...BUSHING, OB TRIPOD LUG (2ND RPR)	2	AR	EA				ALT					
	...3	35-24491-19	3120009136286LE	81205	...BUSHING, OB TRIPOD LUG (3RD RPR)	2	AR	EA				ALT					
	...3	35-24491-20	3120009136288LE	81205	...BUSHING, OB TRIPOD LUG (4TH RPR)	2	AR	EA				ALT					
	...3	66C33001-93A	3120010823914	98747	...BUSHING, OB TRIPOD LUG (5TH RPR)	2	AR	EA				ALT					
	...3	35-24491-21	3120009136289LE	81205	...BUSHING I.B. TRIPOD LUG (1ST RPR)	1	AR	EA									
	...3	35-24491-22	3120009136290LE	81205	...BUSHING I.B. TRIPOD LUG (2ND RPR)	1	AR	EA				ALT					
	...3	35-24491-23	3120009136291LE	81205	...BUSHING I.B. TRIPOD LUG (3RD RPR)	1	AR	EA				ALT					
	...3	35-24491-24	3120009136292LE	81205	...BUSHING I.B. TRIPOD LUG (4TH RPR)	1	AR	EA				ALT					
	...3	66C33001-97A	3120010823912	98747	...BUSHING I.B. TRIPOD LUG (5TH RPR)	1	AR	EA				ALT					
	...3	35-24491-5	3120009136294LE	81205	...BUSHING, LOW TRIPOD LUG (1ST RPR)	2	AR	EA									
	...3	35-24491-6	3120009136295LE	81205	...BUSHING, LOW TRIPOD LUG (2ND RPR)	2	AR	EA				ALT					
	...3	35-24491-7	3120009136296LE	81205	...BUSHING, LOW TRIPOD LUG (3RD RPR)	2	AR	EA				ALT					
	...3	35-24491-8	3120009136297LE	81205	...BUSHING, LOW TRIPOD LUG (4TH RPR)	2	AR	EA				ALT					
	...3	66C33001-89A	3120010823916	98747	...BUSHING, LOW TRIPOD LUG (5TH RPR)	2	AR	EA				ALT					
	...3	35-24491-1	3120009136280LE	81205	...BUSHING, LOW TRIPOD LUG (1ST RPR)	2	AR	EA									
	...3	35-24491-2	3120007613718LE	81205	...BUSHING, LOW TRIPOD LUG (2ND RPR)	2	AR	EA				ALT					
	...3	35-24491-3	3120009135562LE	81205	...BUSHING, LOW TRIPOD LUG (3RD RPR)	2	AR	EA				ALT					
	...3	35-24491-4	3120009136293LE	81205	...BUSHING, LOW TRIPOD LUG (4TH RPR)	2	AR	EA				ALT					
	...3	66C33001-91A	3120010823915	98747	...BUSHING, LOW TRIPOD LUG (5TH RPR)	2	AR	EA				ALT					
	...3	MS75-6-107	3120004719877	80205	...BUSHING, DOOR ACTUATOR	5	AR	EA									
	...3	66C33001-103B	3120010823909LE	98747	...BUSHING, DOOR ACTUATOR	5	AR	EA				INT					
	3	N.P.L.	N.S.L.		...ORFIC HLE ASSY(1ST OS)RPR(PSEUDO)	1	AR										
STL	4	136-7107-1	3120009135551LE	82918	....BUSHING, ORIFICE HOLE (1ST OS)	1		EA									
	4	MS28774-213	5330006186845	96906	....RING, BACKUP (KIT)	1		EA									
	4	MS28782-20	5330001719225	96906	....RING, BACKUP	1		EA				INT					
	4	MS28775-213	5330005797911	96906	....PACKING, O-RING (KIT)	1		EA									
	4	AN6227B20	N.S.L.		....PACKING, O-RING	1						INT					
STL	4	N.P.L.	N.S.L.		...ORIFIC HLE ASSY(2ND OS)RPR(PSEUDO	1	AR					ALT					
STL	4	833971	N.S.L.		....BUSHING, ORIFICE HOLE (2ND OS)	1											
STL	4	1010	N.S.L.	LOC MFG	....BSHING,ORFIC HLE(2ND OS)4130 STE	1						INT		*			
	4	MS28774-216	5330005822142	96906	....RING, BACKUP	1		EA									
	4	AN6246-21	N.S.L.		....RING, BACKUP	1						INT					
	4	MS28775-216	5330006410231	96906	....PACKING, O-RING	1		EA									
	4	AN6227-21	5330001986177	88044	....PACKING, O-RING	1		EA				INT					
	3	N.P.L.	N.S.L.		...ACTUATOR KEYWAY(OS)(RPR)PSEUDO	1	AR										
	4	1011	N.S.L.	LOC MFG	....SLT PLTE(OS RPR)(4340 STEEL)	1								*			
	4	AN74A-7	5306008254422	88044	....BOLT	1		EA									
	4	159-028-125-1000	5315006631301	72962	....PIN	1		EA									

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B-52H AFT

BILL OF MATERIALS

17143A

* = MMI

ROUTED ITEM	FLOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNB NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	..2	AN960D1616L	5310001872394	88044	..WASHER, FLAT	1	EA										
	..2	AN320-6	5310001768110	88044	..NUT, CASTLE SHEAR	3	EA										
	..2	AN960-616	5310010164871	88044	..WASHER, FLAT	3	EA										
	..2	MS21022A17	5310006166857	80205	..NUT, SELF LOCKING	1	EA										
	..2	AN74-3	5306009930500	88044	..BOLT, MACHINE	2	EA										
	..2	AN960-416	5310001411795	88044	..WASHER, FLAT	6	EA										
	..2	MS15001-1	4730000504203	96906	..FITTING, LUB	4	EA										
	..2	MS15001-3	4730000504205	96906	..FITTING, LUB	6	EA										
	..2	MS16624-1150	5365008037299	96906	..RING, RETAINING	1	EA										
	..2	MS21025-24	5310005589763	96906	..NUT, RETAINING	2	EA										
	..2	NAS333CPA-5	5305005516029	80205	..SCREW	12	EA										
	..2	AN960PD2116L	5310005956902	88044	..WASHER, FLAT	5	EA										
	..2	AN960D10L	5315001670752	88044	..WASHER, FLAT	12	EA										
	..2	BACN10BY53N	5310006804892	81205	..NUT, SELF LOCKING	12	EA										
	..2	MS21042L3	5310008071474	96906	..NUT, SELF LOCKING	12	EA					INT					
	..2	AN960D2616L	5310001872360	88044	..WASHER, FLAT	2	EA										
	..2	AN320-18	5310002687307	88044	..NUT, CASTLE	3	EA										
	..2	MS24665-359	5315000137214	96906	..PIN, COTTER	5	EA										
	..2	MS16624-1087	5365008042025	96906	..RING, RETAINING	4	EA										
	..2	682824POH	5310002710663LE	60380	..BEARING, NEEDLE	4	EA										
	..2	123-1951-1300	5310006745213LE	82918	..WASHER, DRAIN TUBE LOCK	1	EA										
STL	..2	123-1313	5305005947255FR	82918	..BOLT, LOCKING	3	EA										
	.1	166A32349-30	1620009675147	98747	.PARTS KIT	1	EA										
	..2	MS28775-447	5330002980321	96906	..PACKING, O-RING	1	EA										
	..2	MS28775-446	5330011868336	81349	..PACKING, O-RING	1	EA										
	..2	MS28775-442	5330011852987	96906	..PACKING, O-RING	1	EA										
	..2	MS28775-215	5330005797911	96906	..PACKING, O-RING	1	EA										
	..2	MS28775-210	5330008380570	96906	..PACKING, O-RING	1	EA										
	..2	MS28775-214	5330005437089	96906	..PACKING, O-RING	1	EA										
	..2	MS28778-8	5330011694315	96906	..PACKING, O-RING	1	EA										
	..2	AN6290-8	5330008080794	88044	..PACKING, O-RING	1	EA					INT					
	..2	MS28778-10	5330012381641	96906	..PACKING, O-RING	1	EA										
	..2	AN6290-10	5330002528326	88044	..PACKING, O-RING	1	EA					INT					
	..2	MS28775-112	5330005992934	96906	..PACKING, O-RING	1	EA										
	..2	MS28774-447	5365009476983	96906	..RING, BACKUP	1	EA										
	..2	29-7871	1620006044265	96906	..RING, BACKUP	1	EA										
	..2	MS28774-442	5330001654527	96906	..RING, BACKUP	1	EA										
	..2	MS28774-215	5330006186845	96906	..RING, BACKUP	1	EA										
	..2	MS28774-214	[illegible]	[illegible]	..RING, BACKUP												

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B-52H AFT

BILL OF MATERIALS

17143A

* = MMI

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
STL	..2	AN42-7A	5306008254432	88044	..BOLT, EYE	1	EA										
	..2	13-80905	1650002160958	81205	..SPRING ASSY	1	EA										
	...3	14-80908	1620003100949	81205	...BOOT	1	EA										
STL	...3	REB3N	3110001735072	21335	...BEARING, ROD END	1	EA										
STL	...3	REB3-1	3110001735072	21760	...BEARING, ROD END	1	EA					INT					
STL	...3	REB3N	3110008393933	38443	...BEARING, ROD END	1	EA					INT					
STL	...3	REPB3NFS428	3110002323179	81205	...BEARING, ROD END	1	EA					SUB					
	...3	AN316-4R	5310002037589	88044	...NUT, CHECK	1	EA										
STL	...3	NR125C	5365008999164	80756	...RING, SNAP	1	EA										
	...3	MS24665-132	5315008392325	96906	...PIN, COTTER	1	EA										
	...3	AN310-4	5310001671285	88044	...NUT, CASTELLATED	1	EA										
BRASS	...3	14-80910	1620003079348	81205	...SLIDE, CENTERING SPRING	1	EA										
STL	...3	14-80906	N.S.L.		...SPRING, COMPRESSION	1											
	...3	14-80907	5306006371944	81205	...ROD, CENTERING SPRING TRUST	1	EA										
BRASS	...3	14-80909	1620003100950	81205	...SLIDE, CENTERING SPRING	1	EA										
AL	...3	13-80911	N.S.L.		...HOUSING ASSY, CENTERING SPRING	1											
	4	NA676AS-004P	3120005420441	80205	....BUSHING, PLAIN	2	EA										
AL	4	13-80912	N.S.L.		....HOUSING, CENTER SPRING	1											
	..2	NAS6203-16	5306010611956	80205	..BOLT, SHEAR	1	EA										
	..2	NAS1197-10L	5310008148313	80205	..WASHER	3	EA										
	..2	NAS1103-14W	5306006168837	99999	..BOLT, SHEAR	2	EA										
STL	..2	NR137C	5365006850484	80756	..RING, SNAP	1	EA										
STL	..2	MS27641KP10A	3110010232533	96906	..BEARING, BALL	1	EA										
STL	..2	AN201KP10A	3110000274028	80059	..BEARING, BALL	1	EA					SUB					
AL	..2	16-44098-2	1620006008213	81205	..SUPPORT, JACKSHAFT	1	EA										
AL	..2	16-44098	1620003421438	81205	..SUPPORT, JACKSHAFT	1	EA					INT					
	..2	BACN10BY54W	5310006807504	81205	..NUT, SELF-LOCKING	2	EA										
	..2	NAS1197-416L	5310008046801	80205	..WASHER	2	EA										
	..2	AN960416	5310001670740	88044	..WASHER, FLAT	2	EA										
	..2	NAS1104-13W	5306005844992	80205	..BOLT, SHEAR	2	EA										
	..2	15-68470-2	1620003079442	81205	..JACKSHAFT ASSY	1	EA										
	...3	BACN10BY53W	5310006804892	81205	...NUT, SELF LOCKING	5	EA										
	...3	AN960D10	5310001834406	88044	...WASHER, FLAT	5	EA										
STL	...3	NAS1103-25W	5306006161746	80205	...BOLT, SHEAR	2	EA										
AL	...3	12-81078-1	1620002148368	81205	...ARM JACKSHAFT	1	EA										
	...3	MS24665-132	5315008392325	96906	...PIN, COTTER	1	EA										
	...3	AN310-5	5310001671286	81352	...NUT, CASTLE	1	EA										
STL	...3	RR81C	5365007215377	80756	...RING, SNAP	1	EA										

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LD=LEAD

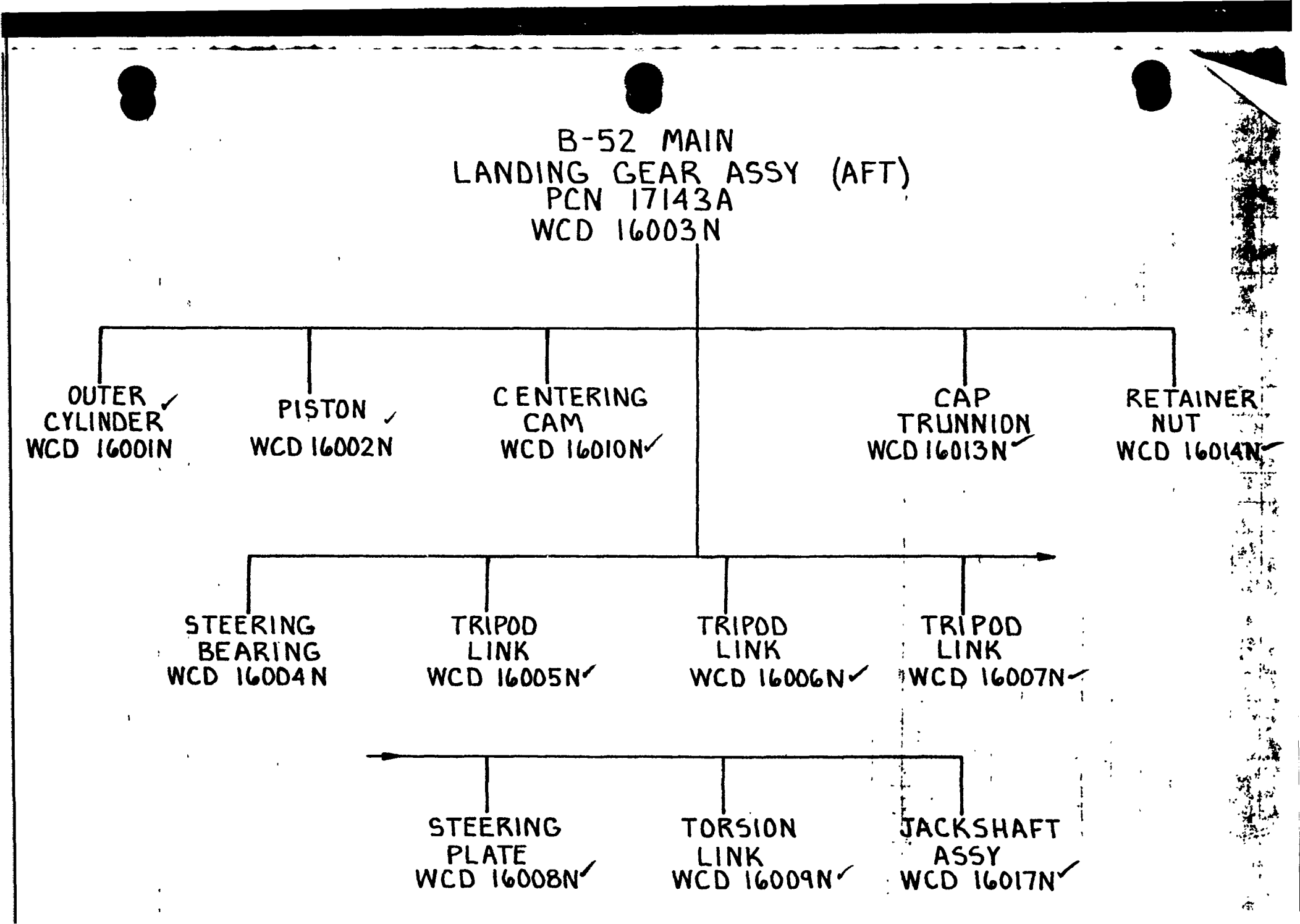
B-52H AFT

BILL OF MATERIALS

17143A

* = MMI

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	...3	AN3-20A	5306001443657	88044	...BOLT, MACHINE	1	EA										
	...3	CR163C4-8	5320002421628	11815	...RIVET	4	EA										
AL	...3	6-47144	1620003421439	81205	...ARM, CRANK	1	EA										
	...3	AN470D6	N.S.L.		...RIVET	4											
AL	...3	15-38911	1620003037500	81205	...ARM, CRANK	1	EA										
	...3	AN426-5	N.S.L.		...RIVET	4											
AL	...3	13-87904	1620003485163	81205	...ADAPTER, JACKSHAFT	1	EA										
	...3	NAS1103-24W	5306007206567	80205	...BOLT, SHEAR	2	EA										
AL	...3	16-45160	N.S.L.		...TUBE, TORQUE	1											
STL	...3	14-80889	N.S.L.		...RING, LOCK	1											
AL	...3	14-80882	N.S.L.		...NUT, JACKSHAFT	1											
STL	...3	MS27642KP21B	3110000420444	91936	...BEARING, BALL	1	EA										
STL	...3	14-80881	1620003485171	81205	...SLEEVE, JACKSHAFT	1	EA										
	...3	RS156C	5365002813635	80756	...SNAP, RING	1	EA										
	...3	14-80888	5365011327509LE	81205	...SHIM, LAMINATED	1	EA										
	...3	14-80876	1620003487947	81205	...GEAR ASSY, JACKSHAFT	1	EA										
SYN	4	14-80880	N.S.L.		....PLUG, GEAR	1											
AL	4	14-80877	N.S.L.		....SHAFT, GEAR	1											
AL	4	14-80878	N.S.L.		....PIN, SHEAR	1											
STL	4	13-80879	3020003204488LE	81205	....GEAR	1	EA										
	...3	013	N.S.L.		...HOUSING JACKSHAFT ASSY	1								*			
	4	MS15-6	5320005791215	73197	....COLLAR	2	EA										
	4	BACR15AY6-7	5320002057320	81205	....RIVET	2	EA										
	4	AN960-10L	5310001670834	88044	....WASHER, FLAT	2	EA										
	4	NAS1197-10L	5310008148313	80205	....WASHER	2	EA										
STL	4	14-80886	1620003485172	81205	....STOP, JACKSHAFT	1	EA										
MAG	4	15-69535	1680005101873	81205	....HOUSING, JACKSHAFT	1	EA										
	...3	014	N.S.L.		...HOUSING JACKSHAFT ASSY	1						INT		*			
	4	6LCC6	5320005518000	29666	....COLLAR	2	EA										
	4	SNLPT6-5	5320005583970	29666	....LOCK BOLT	2	EA										
	4	AN960-10L	5310001670834	88044	....WASHER, FLAT	2	EA										
	4	NAS1197-10L	5310008148313	80205	....WASHER	2	EA										
STL	4	14-80886	1620003485172	81205	....STOP, JACKSHAFT	1	EA										
MAG	4	15-69535	1680005101873	81205	....HOUSING, JACKSHAFT	1	EA										
	.1	BACM10L31-1LT	N.S.L.	81205	.DECAL, STICK ON	1											
	.1	BACM10L73-1BRL	N.S.L.	81205	.DECAL, STICK ON	1											
	.1	BACM10663-1CC	N.S.L.	81205	.DECAL, STICK ON	1											
	.1	PD80	5340008272467	99017	.PLUG, PROTECTIVE	3	EA										
	.1	MS518-10	5340008172773	80205	.PLUG, PROTECTIVE												


B-52 MAIN
LANDING GEAR ASSY (AFT)
PCN 17143A
WCD 16003N
OUTER CYLINDER WCD 16001N
PISTON WCD 16002N
CENTERING CAM WCD 16010N
CAP TRUNNION WCD 16013N
RETAINER NUT WCD 16014N
STEERING BEARING WCD 16004N
TRIPOD LINK WCD 16005N
TRIPOD LINK WCD 16006N
TRIPOD LINK WCD 16007N
STEERING PLATE WCD 16008N
TORSION LINK WCD 16009N
JACKSHAFT ASSY WCD 16017N

16003N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89046 PAGE __ OF __ PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4S-1-182 &4S1-57-3	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
B-52 MAIN		

13. SERIAL NUMBER	14 NOUN
	STRUT ASSY

17142A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
7027648-190		1620001398473 17142A			
7027648-210		1620001398474 17143A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT			
		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND			
		T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 959. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH			
		THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH			
		STATIONS. WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF			
		EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO			
		PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA			
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16003N
		B	D	

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AFLC FORM 959 NOV 80

★ U.S. GOVERNMENT PRINTING OFFICE: 1980—646-183

16003N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89046 | PAGE 2 OF ___ PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	STRUT ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		STAMP.			
	001	7027648-190 7027648-210			
	010 *REQD*	*MATCH-UP* ROUTED COMPONENTS NEW/SERVICEABLE REWORK NO REWORK OUTER CYL.		001 MNPGP 002 06 003 MU01	
		16001N PISTON 16002N CAM			
		16010N CAP TRUNNION 16016N PSTN HD NUT			
		16014N N O T E :THERE ARE 12 MISC DOCUMENTS			
	500 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING 950 THIS PACKAGE *C/P MOVE	10	001 MNPGP 002 06 003 MU01	
	501 *REQD*	PRE ASSY CLEANING INSPECTION CHECK CAVITIES & INTERIOR FOR FOREIGN MATERIAL PRIOR TO REASSEMBLE *C/P MOVE	30	001 MNPGP 002 06 003 SA03	
	502 *REQD*	REASSEMBLE INTERNAL PARTS PRIOR TO INSTALLING TRUNNION CAPS COAT THE TRUNNION BEARING AREA WITH	150	001 MNPGP 002 06 003 SA03	
		MIL-S-81733 CLASS A TYPE 1-1/2 IN ADDITION TO THE ZINC CHROMATE PRIMER TYPE 1-2 IS A SUITABLE SUBSTITUTE IF (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16003N
		B	D	

PREVIOUS EDITION WILL BE USED

★ U.S. GOVERNMENT PRINTING OFFICE: 1988—548-163

16003N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89046 — PAGE 3 OF ___ PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	STRUT ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		TYPE 1-1/2 IS NOT AVAILABLE TRUNNION CAP SMALL O.D. 4.746/4.742			
		TRUNNION CAP LARGE O.D. 4.846/4842 *C/P MOVE			
[redacted]	504 *REQD*	OK TO CLOSE AND/OR ASSEMBLE @*@*@*@*@*@" N O T E "@*@*@*@*@*@*@*@* USE ONLY AXLE NUT WITH P/N MS21025	6	001 MNPGP 002 06 003 SA03	
		OR LETTER "X" STAMPED NUT @*			
[redacted]	505 *REQD*	CAM ALIGNMENT *C/P MOVE	3	001 MNPGP 002 06 003 SA03	
[redacted]	506 *REQD*	CHECK STROKE IAW T.O. *C/P MOVE XXXXXXXXXX(" N O T E "))XXXXXXXXXXX	3	001 MNPGP 002 06 003 SA03	
		TORQUE ALL NUTS & BOLTS IAW T.O. XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX	2D		
[redacted]	507 *REQD*	PRESSURE TEST *C/P MOVE		001 MNPGP 002 06 003 TL07	
[redacted]	509 *REQD*	TEST TRUNNION PORTS IAW T.O CHANGE *C/P MOVE		001 MNPGP 002 06 003 TL07	
[redacted]	511 *REQD*	*MATCH-UP* ----------ROUTED COMPONENTS---------- NEW/SERVICEABLE REWORK NO REWORK (CONTINUED)		001 MNPGP 002 06 003 FA08	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16003N
		B	D	

AFLC FORM 858 NOV. 80 PREVIOUS EDITION WILL BE USED

★ U.S. GOVERNMENT PRINTING OFFICE: 1980—646-163

16003N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89046 | PAGE 4 OF PAGES

2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 *OPTIONAL

13. SERIAL NUMBER	14 NOUN
	STRUT ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		STEERING BEARINGS 16004N LOWER TRIPOD			
		16005N OUTBRD TRIPOD 16006N INBRD TRIPOD			
		16007N STEERING PLATES 16008N TORQUE ARM			
		16009N JACK SHAFT ASSY 16017N			
[redacted]	513 *REQD*	PRE-FINAL INSPECTION		001 MNRGP 002 06 003 FA08	
[redacted]	514 *REQD*	ASSEMBLE *C/P MOVE		001 MNRGP 002 06 003 FA08	
[redacted]	515 *REQD*	MASK, PRIME AND PAINT *C/P MOVE		001 MNRGP 002 09 003 WB03	
[redacted]	520 *REQD*	DECALS *C/P MOVE		001 MNRGP 002 09 003 WB03	
[redacted]	535 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY		001 MNRGP 002 09 003 WB03	
[redacted]	540 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNRGP 002 09 003 WB03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16003N
		B	D	

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16003N **WORK CONTROL DOCUMENT (MEDS)**

1. DATE 89048 PAGE 3 OF 3 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. *OPTIONAL

13. SERIAL NUMBER	14. NOUN
	STRUT ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16003N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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★ U.S. GOVERNMENT PRINTING OFFICE: 1980—840-163

16001N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89046 | PAGE 1 OF ___ PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	1. 45-1-182 2. 451-57-3	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
M52 MAIN		

13. SERIAL NUMBER	14. NOUN
	OUTER CYLINDER ASSY

17142A

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 7027516-10		NSN [redacted] C/N 17142A 17143A			
		***** UNIT COST: $[illegible] *****			
		FPI IAW MIL-STD-[illegible] STRIP ANODIZE IAW MIL-[illegible] SHOT PEEN IAW MIL-S-[illegible] ANODIZE IAW MIL-A-[illegible]			
		BLAST IAW MIL STD-[illegible] BRUSH PLATE IAW MIL-[illegible] 45-[illegible] [illegible] IAW MIL-C-[illegible]			
		FLAME SPRAY IAW MIL-STD-[illegible]			
		ALL PERSONNEL INVOLVED IN THE [illegible] PROCESSES SHALL BE [illegible] [illegible] SHALL BE [illegible] [illegible]			
		PRACTICES AND [illegible] THE PART [illegible] T.O. [illegible] APPLICABLE [illegible]			
		WILL ALWAYS [illegible] WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MUST [illegible]			
		MOVES BETWEEN OPERATIONS/[illegible] STATIONS. WARNING MANY OF THE FOLLOWING REPAIR			
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16001N
		B	D	

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16001N **WORK CONTROL DOCUMENT (MEDS)** [redacted] PAGE __ OF __ PAGES

2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14. NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PERSONNEL AND EQUIPMENT SAFEGUARDING AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		*REQ'D (QUANTITY REQUIREMENT) IN COLUMN 16 IS A DIRECTIVE TO DELTA STA**			
	001	*02*16-10			
[redacted]	*REQD*	I*SPECT* *D/P MOVE NOTE REMOVE ALL BUSHINGS. CAUTION: DO NOT USE CYLINDERS WITH PART NUMBERS		001 MNPGW 002 02 003 MI02 004 ZY45/50	
		25-2 01-502 25-A101 502 [illegible]		001 XR 45234	
[redacted]	*REQD*	[illegible] *D/P MOVE		001 MNPGW 002 03 003 AL02	
[redacted]	*REQD*	[illegible]		[illegible] 002 03 003 [illegible]	
[redacted]	*REQD*	STEEL BANDING *D/P MOVE		[illegible] 002 03 003 AN03	
[redacted]	*REQD*	*D/P MOVE	M	001 MNPNA 002 05 003 ZY05	
[redacted]		E & I INSPECTION CAUTION: DO NOT USE CYLINDERS WITH PART NUMBERS: (CONTINUED)		001 MNPGW 002 04 003 EI01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16001N
		B	D	

APLC FORM 958 NOV 80 PREVIOUS EDITION [illegible]

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16001N **WORK CONTROL DOCUMENT (MEDS)**

1. DATE 89046 | PAGE 3 OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	OUTER [illegible] SHAFT

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		25-4201-507 25-4201-509 5-[illegible]			
		[illegible] OUTER DIA INNER CASE FOR INSP-[illegible] [illegible]			
		1.250/1.251 WLDG 1.252 INNER [illegible] LUG 1.112/1.113 [illegible]			
		[illegible] 71 70 [illegible] 625/1.626 WELDM 1.621" [illegible]			
		[illegible] 1.498/1.502 STEERING LUG 1.500/1.510 WELDM 1.[illegible] [illegible]			
		WELDM 1.250 ACTUATOR LUG (LARGE) 1.750/1.7510 [illegible] [illegible] FOR BASE METAL			
		[illegible] [illegible] 3.500/3.506 WLDG [illegible]			
		OUTBOARD TRIPOD LUGS 1.370/1.402 INBOARD TRIPOD LUGS 1.4375/1.4705			
		LOWER TRIPOD LUGS 1.750/1.784 STEERING LUG 1.750/1.822			
		ACTUATOR LUGS (SMALL) 1.538/1.570 (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16001N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE 1988—548-163

16001N **WORK CONTROL DOCUMENT (MEDS)**

1. DATE 890[redacted] PAGE__OF__PAGE[redacted]

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN	
	OUTER STEERING KEY	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		ALTER OR CURE LEVEL 2.3[illegible] DOOR ACTUATOR FIG 2-2 INDEX 144,145 [illegible]			
		DOOR ACTUATOR FIG 2 INDEX [illegible]			
		DOOR ACTUATOR FIG 2-2 INDEX [illegible] [illegible]			
		[illegible] OUTER CYL & STEERING CLAMP FIG 2-2 [illegible]			
		OUTER CYLINDER [illegible]			
		OUTER CYL [illegible]			
		[illegible]			
		IF [illegible] FACE TO FACE [illegible] ORIFICE TUBE HOLE 1.000/1.004			
		OVERSIZE ORIFICE HOLE 1.3[illegible]/1.318 UPPER & LOWER STEERING JOURNAL 10.875/10.878 IF PLATED [illegible] DIA IS 10.870 FACE TO FACE 1.811/1.813/1.819			
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16001N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SIC/RCC	5. DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTBD CYLINDER ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "C
		OUTBD ACTUATOR HOLES .4388/.4406 NOTE: REMOVE ALL BUSHINGS IF			
		MFG SHOP AND CHECK TO SEE THAT BUSHINGS REMOVED FROM TRUNNION END AND ALL BUSHINGS ARE REMOVED			
		NOTE: 100% COMPLIANCE OF SHOT PEEN PER C.D. IS MANDATORY. ********** N O T E ********** * ALL OUTBD ACTUATOR HOLES MUST BE SHOT PEENED *			
		********** N O T E ********** *C/P MOVE			
69	060	OUTBOARD TRUNNION COUNTER BORE REMOVE 0.010 TO 0.015 MACHINE TO ID FIG 2-25 .485 REAM 9.0/8.030 .030 *C/P MOVE		001 MNPRA 002 03 003 MH04 005 X863363	
69	065	INBOARD TRUNNION HYDRAULIC TUBE REPAIR IAW PAGE 2-33 PARA 2-32 FIG 2-25 *C/P MOVE		001 MNPRA 002 03 003 MH04 005 X863363	
69	070	KEYWAYS CENTERING CAM REPAIR MACHINE NEW KEYWAYS IAW FIG 2-24 125 RMS *C/P MOVE		001 MNPRA 002 03 003 MH04 005 X863363	
69	080	REMOVAL OF OLD DAMAGED KEYWAYS IAW FIG 2-24 MACH KEYWAYS WITH A 5 TO 1 RUNOUT TO BOTTOM OF KEYWAYS STAMP K AFTER S/N 125 RMS *C/P MOVE		001 MNPRA 002 03 003 MH04 005 X863363	
69	100	OUTBOARD TRUNNION REPAIR, REPAIR IAW PAGE 2-30 PARA 2-29 FIG 2-25 T.O. 4S1-57-3 63RMS (CONTINUED)		001 MNPRA 002 03 003 MH04 005 X863363	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16001N
		B	D	

AFLC FORM 958 NOV 80 PREVIOUS EDITION WILL BE USED

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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTLY TRUNNION ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		MAT MOVE			
69	110	INBOARD TRUNNION REPAIR. REPAIR IAW PAGE 2-30 PARA 2-37 FIG 2-21 TO .931-.932 63 RMS *C/P MOVE		001 MNHRA 002 03 003 MH04 005 [illegible]	
69	120	OUTBOARD TRUNNION RADIUS REPAIR IAW FIG 2-23, STAMP LETTER "T" .125 DEEP *C/P MOVE		001 MNHRA 002 03 003 SE01	
69	130	INBOARD TRUNNION RADIUS REPAIR FIG 2-23 PARA 2-37		001 MNHRA 002 03 003 SE01	
69	240	ORIFICE TUBE HOLE REPAIR IAW FIG 2-23 CLEANUP TO 1.309/1.310 ON 1 [illegible] 63 RMS .001/.0015 [illegible]		001 MNHRA 002 03 003 MH04 005 X8633632	
		32 RMS *C/P MOVE			
69	260	OUTBOARD TRIPOD LUG HOLE REPAIR LINE BORE AND ROLL MAX TO 1.407 63 RMS *C/P MOVE		001 MNHRA 002 03 003 MH04 005 X8633632	
69	280	INBOARD TRIPOD LUG HOLE REPAIR LINE BORE AND ROLL MAX ID 1.[illegible] 63 RMS ~~*C/P MOVE~~		001 MNHRA 002 03 003 MH04 005 X8633620	
69	300	LOWER TRIPOD LUG HOLE REPAIR. LINE BORE AND ROLL MAX ID 1.782 63 RMS *C/P MOVE		001 MNHRA 002 03 003 MH04 005 X8633632	
69	320	STEERING LUG HOLE REPAIR (INBOARD) LINE BORE AND ROLL TO MIN I.D. 1.750 63 RMS PARA 2-38 (CONTINUED)		001 MNHRA 002 03 003 MH04 005 X8633632	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16001N
		B	D	

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16001N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89046 | PAGE 7 OF PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14. NOUN
	OUTER CYLINDER ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
69	340	STEERING LUG HOLE REPAIR (OUTBOARD) LINE BORE AND ROLL TO MIN I.D [illegible] PARA 2-36 *C/P MOVE		001 MNPRA 002 03 003 MH04 005 X8433632	
69	360	STEERING LUG COUNTERBORE REWORK IAW PARA 2-32 AND 2-33 AND FABRICATE SPECIAL BUSHING IAW FIG 2-19 63RMS *C/P MOVE		001 MNPRA 002 03 003 MH04 005 X8433632	
		P/N 6-35130-503 P/N 39-21477-7 P/N 39-21477-8 P/N 39-21477-9			
		P/N 66C33000-595 P/N 35130-502 P/N 39-21477-10 P/N 39-21477-11			
		P/N 39-21477-12 P/N 66C33000-595			
69	380	ACTUATOR LUG HOLE REPAIR (SMALL) LINE BORE AND ROLL TO MAX ID 1.5[illegible] 63 RMS *C/P MOVE		001 MNPRA 002 03 003 MH04 005 X8433632	
69	400	ACTUATOR LUG HOLE REPAIR (LARGE) LINE BORE AND ROLL TO MAX ID 2.071 63 RMS *C/P MOVE		001 MNPRA 002 03 003 MH04 005 X8433632	
69	420	ACTUATOR LUG KEY SLOT REPAIR IAW PARA 2-36 AND FIG 2-18 AND FABRICATE PLATE FROM 4340 STEEL, HEAT TREAT 160,000/180,000 PSI		001 MNPRA 002 03 003 MH04 005 X8433632	
		63RMS *C/P MOVE P/N 011 (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16001N
		B	D	

AFLC FORM 938 NOV 80 PREVIOUS EDITION WILL BE USED

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★ U.S. GOVERNMENT PRINTING OFFICE: 1980—640-163

16001N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89046 | PAGE 8 OF ___ PAGES

2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 *OPTIONAL

13. SERIAL NUMBER	14. NOUN
	OUTER CYL LUG HOLE

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		P/N 01			
69	.425	DOOR ACTUATOR LUG REPAIR INDEX 146 REAM HOLES TO A DIA OF [illegible] ROLL BURNISH HOLES TO A [illegible] 63RMS *C/P MOVE		001 MNPRA 002 03 003 BE01	
69	430	DOOR ACTUATOR LUG REPAIR (5 EA) INDEX 144/145 REAM HOLES TO A DIA OF .358/.362 ROLL BURNISH HOLES TO A DIA .361/.365 63RMS *C/P MOVE		001 MNPRA 002 03 003 BE01	
69	440	DOOR ACTUATOR LUG HOLE REPAIR (5 EA) INDEX 144/145 MACH TO CLEANUP FOR BURNISHING & ROLL BURNISH. MACH TO .[illegible] 63RMS *C/P MOVE		001 MNPRA 002 03 003 BE01	
69	443	REAM LUG HOLE INDEX 147 TO .308/.310 & ROLL BURNISH TO .309/.3115 63 RMS *C/P MOVE		001 MNPRA 002 03 003 BE01	
69	446	O/S LUG HOLE INDEX 147 TO .312/.313 & ROLL BURNISH TO .3145/.3175 63RMS *C/P MOVE		001 MNPRA 002 03 003 BE01	
69	460	REAM LUG HOLE INDEX 148 TO .342/.344 & ROLL BURNISH TO .3430/.3435 63 RMS [illegible] *C/P MOVE		001 MNPRA 002 03 003 BE01	
69	470	O/S LUG HOLE INDEX 148 TO .379/.380 & ROLL BURNISH TO DIA INCREASE .381/.3815 63RMS *C/P MOVE		001 MNPRA 002 03 003 BE01	
69	480	REAM LUG HOLE INDEX 151 TO .257/.259 & ROLL BURNISH TO .2580/.2605 63 RMS *C/P MOVE		001 MNPRA 002 03 003 BE01	
69	490	O/S LUG HOLE INDEX 151 TO .2651/.2661 & ROLL BURNISH TO .2684/.2704 63RMS *C/P MOVE		001 MNPRA 002 03 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16001N
		B	D	

AFLC FORM 958 NOV 80 EXCLUSIVE REVISION WILL BE USED

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16001N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89046 | PAGE 9 OF 9 PAGES

2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER ASSY

15. DISPATCH STATION	16. *ERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	500	REAM LUG HOLE INDEX 150 (MEA) I/C .1935/.1955 & ROLL BURNISH TO .1970 COLD WORK FINAL SIZE .2050/.2078 *C/P MOVE		001 MNPRA 002 03 003 BE01	
69	502	REAM LUG HOLE INDEX 149 TO.1969/ .1977 IF NOT FOUND GO TO 1ST OR 2ND O/S 1ST O/S ROLL BURNISH TO [illegible]		001 MNPRA 002 03 003 BE01	
		2ND O/S ROLL BURNISH TO .2024/.2214 & REMS *C/P MOVE			
69	504	UPPER STEERING JOURNAL MACHINE OFF ONLY ENOUGH MATERIAL TO REMOVE REFELT MAX OF .07 INCH DEPTH *C/P MOVE		001 MNPRA 002 03 003 LE13 005 X8338622	
69	506	LOWER STEERING JOURNAL MACHINE OFF ONLY ENOUGH MATERIAL TO REMOVE REFELT MAX OF .07 INCH DEPTH *C/P MOVE		001 MNPRA 002 03 003 LE13 005 X8338622	
69	508	NICK AND BURR DAMAGED AREA ONLY IAW T.O. 4S1-57-3 FIG 2-20 AND PARA 2-28 FOR EXTERNAL AND PARA 2-32 FOR INTERNAL *C/P MOVE		001 MNPRA 002 03 003 BE01	
69	521	POLISH CYLINDER I.D. UPPER BORE NOT TO EXCEED .006 IN DEPTH MAX STM [illegible] *C/P MOVE		001 MNPRA 002 03 003 BE01	
[redacted]		* * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *	M	001 MNPRA 002 05 003 ZY05	
8G	525	HONE CYL I.D. UPPER BORE MAX. [redacted] 9.248/9.257 *C/P MOVE		001 MNPRB 002 03 003 HV04 005 X8745190	

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2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER TRUNNION ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
16 [redacted]	542	DEBURR ALL *C/P MOVE		(illegible) MAINT 002 03 003 IG01	
16 [redacted]	550	*BRUSH PLATE I.D. OF OUTBOARD TRUNNION (OBT) BY HAND TO REMOVE CORROSION AS PER T.O. 42A2-2-30 *C/P MOVE		001 MNFRL 002 01 003 SP01	
16 [redacted]	540	SHOT PEEN EXTERNAL SURFACES COMPLETE NOTE: 100% COMPLIANCE IS MANDATORY. *C/P MOVE		001 MNFRL 002 01 003 SP01	
16 [redacted]	550	SHOT PEEN IF PITS ARE LESS THAN 0.5% IN DEPTH .029/.035 SIZE CCW-28 COVERAGE OF 150% TO 400% *C/P MOVE		001 MNFRL 002 01 003 SP01	
16 [redacted]	560	SHOT PEEN ALL REWORKED AREAS ONLY *C/P MOVE		001 MNFRL 002 01 003 SP01	
16 [redacted]	562	(illegible) AFTER SHOT PEEN TO REMOVE 80% TO 85% OF SHOT PEEN DEPRESSION *C/P MOVE		001 MNFRL 002 03 003 BE01	
16 [redacted]	570	POLISH SHOT PEENED BEARING LANDS LARGE TRUNNION LANDS 4.058/4.050 SMALL TRUNNION LANDS 4.050/4.042 *C/P MOVE		001 MNFRL 002 03 003 BE01	
16 [redacted]	581	POLISH SHOT PEENED BEARING LANDS STEEP MG BEARING 10.875/10.870 *C/P MOVE		001 MNFRL 002 02 003 BE01	
[redacted]		*C/P MOVE		001 MNFWW 002 08 003 DG02	
[redacted]		ING 180 ALUMINUM OXIDE GRIT *C/P MOVE		001 MNFWW 002 08 003 BL01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		[redacted] USING METCO ALUMINUM TO ALLOW FINAL MACH TO 10.875/10.878 OD 1.810/1.813 WIDTH .09/.12 RADIUS IN SHOULDERS		001 MNFRA 002 08 003 F004 005 XE029475	WW
		*C/P MOVE			
		[redacted] LOWER JOURNAL USING METCO ALUMINUM TO ALLOW FINAL MACH TO 10.875/10.878 OD 1.810/1.813 WIDTH .09/.12 RADIUS IN SHOULDERS		001 MNFRA 002 08 003 F004 005 XE029475	WW
		*C/P MOVE			
69	610	MACHINE UPPER STEERING JOURNAL TO 10.875/10.878 OD 1.810/1.813 WIDTH A .09/.012 INCH RADIUS IN SHOULDERS 32 RMS FINISH *C/P MOVE		001 MNFRA 002 03 003 [illegible] 005 XE029475	
69	615	MACHINE LOWER STEERING JOURNAL TO 10.875/10.878 OD 1.810/1.813 WIDTH A .09/.012 INCH RADIUS IN SHOULDERS 32 RMS FINISH *C/P MOVE		001 MNFRA 002 03 003 LE03 005 XE029475	
22	630	ANNULAR CYLINDER COMPLETE TYPE II *C/P MOVE		001 MNFRA 002 03 003 [illegible] 005 XE029475	
69	640	ALODINE REMOVED AREAS ONLY *C/P MOVE		001 MNFRA 002 03 003 TA01	
69	650	FLANGED BUSHINGS INSTALLATION SHALL HAVE A MIN OF 10% FLANGE CONTACT MAX .020 ALLOWABLE GAP. SEAL GAP WITH MIL-S-8802 B-2 81349 REF 4S1-57-3		001 MNFRA 002 03 003 LE02	
69	675	MACHINE INBOARD TRIPOD LUG BUSHING O.D. TO FIT HOLE P/N 35-24491-21 (CONTINUED)		001 MNFRA 002 03 003 LE02	

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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		P/N 35-2449[illegible]-22 P/N 35-2449[illegible]-23 P/N 35-2449[illegible]-24 P/N [illegible]			
69	680	INBOARD TRIPOD LUG BUSHING INSTAL- LATION 35-2449[illegible] [illegible]		[illegible]	
		[illegible] RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED			
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
69	690	MACHINE OUTBOARD TRIPOD LUG BUSHINGS O.D. [illegible] [illegible]		[illegible]	
		P/N 35-2449[illegible]-21 P/N 35-2449[illegible]-22 P/N [illegible] P/N [illegible]			
		P/N 35-2449[illegible]-19 P/N 35-2449[illegible]-19 P/N 35-2449[illegible]-20 P/N [illegible]			
69	700	OUTBOARD TRIPOD LUG BUSHING INSTAL- LATION P/N 35-2449[illegible] FOR CENTER LUG-17-18-19-20 FOR OUTSIDE LUG, OR MORE [illegible]		[illegible] 003 BE01	
		REAM 1.250/1.2[illegible] RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED			
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			

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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	710	MACHINE LOWER TRIPOD LUG BUSHINGS O.D. TO FIT HOLES *C/P MOVE P/N 35-24491-5 P/N 35-24491-3		001 MNFRA 002 03 003 LE02	
		P/N 35-24491-7 P/N 35-24491-3 P/N 66E33001-091 P/N 35-24491-1			
		P/N 35-24491-7 P/N 35-24491-3 P/N 35-24491-5 P/N 66E33001-91A			
69	720	LOWER TRIPOD LUG BUSHING INSTALLATION 35-24491 FOR OUTSIDE LUG 1-2-3-4 FOR INSIDE LUG, OR MAKE IAW FIG 2-28 FINISH REAM 1.625/1.626		001 MNFRA 002 03 003 BE01	
		(PARA 2-56.2) 63RMS RE JAU MEAS DIM IF REWORK LIMITS ARE EXCEED			
		RECORD WEAR DIM IF CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
69	730	MACHINE INBOARD ACTUATOR LUG BUSHING O.D. TO FIT HOLE *C/P MOVE P/N 3-1501 P/N 39-21472-3			
		P/N 39-21472-1 P/N 39-21472-2 P/N 66E33000-635			
69	740	INBOARD ACTUATOR LUG BUSHING INSTALLATION 39-21477 OR MAKE IAW FIG 2-28 PRESS FIT .001/.002, FINISH LINE REAM 1.750/1.751		001 MNFRA 002 03 003 BE01	
		(PARA 2-56.2) 63RMS RECORD WEAR DIM IF REWORK LIMITS ARE (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
69	750	MACHINE OUTBOARD ACTUATOR LUG BUSHING I.D. TO [illegible] MOL *C/P MOVE P/N 39-21422-2 P/N 39-21423-2 P/N 39-21424-2		[illegible] MINS [illegible] 03 [illegible] 1502	
69	760	OUTBOARD ACTUATOR LUG BUSHING INSTALLED FOR JO 2 477 [illegible] MAKE IAW FIG 2-28 [illegible] [illegible]		[illegible] MINS [illegible] 03 [illegible] 2001	
		REAM [illegible] 201 [illegible] RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED			
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
69	770	MACHINE STEERING LUG BUSHINGS O.D. TO FIT HOLES.		[illegible] MINS [illegible] 03 [illegible] 1501	
69	780	STEERING LUG BUSHING INSTALLATION 39 21477 (LONG) (SHORT) OR MAKE IAW FIG 2-28 FINISH LINE REAM		[illegible] MINS [illegible] 03 [illegible] 2001	
		1.500/1.501 [illegible] 63RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED			
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	GUIDE CYLINDER ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	720	TAP OUT THREADS 6 EA HOLES IN TRUNNION 1b AND 3 EA ON SIDE. IF REQUIRING HELICOILS GO TO OP 800 +C/P MOVE		001 MNF 002 03 003 BE0	RA 1
69	800	INSTALL HELICOILS AND OTHER STEEL PARTS AS NEEDED +C/P MOVE		001 MNF 002 03 003 BE0	RA 1
69	810	MACHINE DOOR ACTUATING LUG BUSHING O.D. TO FIT HOLES +C/P MOVE P/N [illegible] 107 P/N [illegible]		001 MNF 002 03 003 LE0	RA 2
69	820	DOOR ACTUATING LUG BUSHING INSTALLA TION (5 EA) INDEX 144/145 MFG FROM 4130 STEEL H.T. 125,000/145,000 PSI [illegible] PRINT NAS75-6 PAGE 2-43 PRESS		001 MNF 002 03 003 BE0	RA 1
		FIT .0017.002 FINISH REAM TO I.D. .2[illegible] [illegible]35 63 RMS RECORD [illegible] ITEM IF REWORK LIMITS ARE [illegible]			
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS +C/P M[illegible]			
69	840	MACHINE OVERSIZE ORIFICE [illegible] BUSHING [illegible] FIG 2-22, 4130, 4340, [illegible] [illegible]		001 MNF 002 03 003 LE0	RA 2
		* * * * * * * * * * * * * * * * * * CAD PLATE AND BAKE 3 HRS AT 350 400F * * * * * * * * * * * * * * * * * * P/N 36-7107-1			
		P/N 855971 P/N 010			
[redacted]	920 +REGDP	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNF 002 06 003 SA0	GP 3

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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1 DATE [redacted] PAGE__OF__PAGES

2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14. NOUN
	OUTER CYLINDER ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	930	FINAL PROJECT VISUAL INSPECTION		001 MNT	GP
	REQD	* C/P MOVE		002 06	
				003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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APLC FORM 6A8 NOV 69

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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
		MNPGP		

7 PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO
	1. 4S-1-182 2. 4S1-57-3	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
B-52 MAIN		

13. SERIAL NUMBER	14 NOUN	
	CYLINDER ASSY	17142A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
5-85120-6		1620006582588 17142A			
25-4204		1620006525469 17143A			
25-4204-1		1620007838023			
25-4204-4		N.S.L.			
25-4204-5		N.S.L.			
		****** UNIT COST: $4664.00 ******			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		FMPI IAW MIL-STD-1949 P/O NO1561			
		STRIP CHROME IAW MIL-STD-871			
		GRIND IAW MIL-STD-866			
		TEMPER ETCH IAW MIL-STD-867			
		SHOT PEEN IAW MIL-S-13165			
		GRIT BLAST IAW MIL-STD-1504			
		CHROME PLATE IAW MIL-STD-1501			
		CAD PLATE IAW MIL-STD-870			
		BAKE IAW 4S-1-182 MAOI 74-12			
		FPI IAW MIL-STD-6866			
		VAC IVD ALUM PLATE IAW MIL-C-83488A			
		POLYURETHANE PRIMER IAW MIL-P-23377			
		POLYURETHANE PAINT IAW MIL-C-27725			
		ALODINE IAW MIL-C-5541			
		*****STEEL 220,000/240,000 PSI******			
		ALL PRESONNEL INVONVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE			
		FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND (CONTINUED)			

21 FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	CYLINDER ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF			
		EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNE. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO			
		PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA			
		STAMP.			
	001	5-85123-6 25-4204 25-4204-1 25-4204-4			
		25-4204-5			
		DISASSEMBLE *C/P MOVE NOTE: REMOVE ALL BUSHINGS.		001 MNPGW 002 02 003 MI03 005 X8745250	
	REQD			006 X8745234	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN	
	CYLINDER ASSY	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		CHEM CLEAN		001 MNPGW	
		*C/P MOVE		002 03	
	REQD			003 SL 01	
[redacted]		BLAST CLEAN ONLY *C/P MOVE		001 MNPGW	
				002 03	
	REQD			003 BL 01	
[redacted]		BAKE 4HRS AT 350-400F		001 MNPGW	
		DATE IN_____TIME IN_____		002 03	
	REQD	DATE OUT_____TIME OUT_____		003 BK 03	
		*C/P MOVE			
[redacted]				001 MNPNA	
		"NOTE"	M	002 05	
	REQD	WITH THE SINGLE HOLE UP AND TORQUE		003 ML 04	
		ARM LUGS DOWN AND PISTON FACING			
		AWAY FROM YOU THE JOURNALS ARE			
		NUMBERED FROM "L" TO "R" 1-3-4-2			
		*C/P MOVE			
[redacted]		E & I INSPECTION		001 MNPGW	
				002 04	
	REQD	BORE SEAL I.D. 7.732/7.735/7.740 MAX		003 EI 01	
		PISTON O.D. 8.495/8.497			
		PISTON I.D. 7.817/7.826			
		AXLE JOURNAL #1 4.998/4.999			
		AXLE JOURNAL #2 4.998/4.999			
		AXLE JOURNAL #3 5.248/5.249			
		AXLE JOURNAL #4 5.248/5.249			
		TORQUE ARM LUGS I.D 1.751/1.7525			
		JACK PAD BOLT HOLE I.D. .266/.270			
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN	
	CYLINDER ASSY	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		TOWING LUG HOLES I.D. .515/.535 **********N O T E********** IF AXLE THREAD AREA IS CRACKED			
		INITIATE OPERATIONS 272 & 630 ********** N O T E ********** * A MINIMUM OF AT LEAST TWO FMPI'S * * IS REQUIRED.			
		********** *C/P MOVE			
69	100	BRAKE MOUNTING BOLT HOLE CRACK REPAIR: CUT A SLOT .100 INCH WIDE TO REMOVE CRACK. THIS WORK IS ONLY ALLOWED ON 1 EACH HOLE PER SIDE		001 MNPRA 002 03 003 MH04	
		*C/P MOVE			
69	120	JACK PAD BOSS REPAIR IAW FIG 2-26, 125 RMS *C/P MOVE		001 MNPRA 002 03 003 DR05 005 X874554	
69	140	WELD SPLATTER REWORK INSIDE DIAMETER MACHINE WELD SPLATTER IAW 4S1-57-3 NOTE: IS NOT MACHINED REFER TO OPERATION #902 AND STAMP TO BE GRIT		001 MNPRA 002 03 003 BE01	
		BLASTED. ALSO OPERATION #990 FOR POLYURETHANE PAINT. *C/P MOVE			
69	150	MODIFY RETAINER NUT HOLES IAW FIG 2-27B WITH 63 RMS *C/P MOVE		001 MNPRA 002 03 003 DR05	
69	160	REPAIR RETAINER NUT LOCK BOLT HOLES IAW FIG 2-27B PAGE 2-60C OR 2-60D OR 2-60E OR 2-60F *C/P MOVE		001 MNPRA 002 03 003 DR05	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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		B	D	

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2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7 PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	CYLINDER ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	[redacted]	DRILL NEW RETAINER NUT LOCK BOLT HOLES I A W FIG 2-27B PAGE 2-60G *C/P MOVE		001 MNPRA 002 03 003 DR04 005 X863360	
69	220	TORQUE ARM ATTACHING LUG REPAIR OVERSIZE LUG TO DIM OF 1.812/1.831 125 RMS *C/P MOVE		001 MNPRA 002 03 003 DR05	
69	240	TOW LUG HOLE REPAIR FIRST OVERSIZE TO DIM OF .703/.706 *C/P MOVE		001 MNPRA 002 03 003 DR05	
69	260	TOW LUG HOLE REPAIR SECOND OVERSIZE MAX DIM OF .716 *C/P MOVE		001 MNPRA 002 03 003 DR05	
69	270	REPAIR HYDRAULIC FITTING HOLES 2-27C 200 RMS *C/P MOVE		001 MNPRA 002 03 003 MH04	
69	272	CRACKS IN THE AXLE THREAD AREA MAYBE REMOVED BY MACHINING A NOTCH, .365/.385 WIDE AND .470/.530 LONG. MACHINE A .178/.198 RADIUS IN THE BASE OF THE NOTCH. NO MORE THAN TWO NOTCHES SHALL BE PERMITTED IN A 90 DEGREE QUADRANT, AND SHALL BE SPACED AT LEAST 1/4 APART. *C/P MOVE		001 MNPRA 002 03 003 MH04	
[redacted]		REMOVE CRACK OR CRACK INDICATION IN INNER CYLINDER.KEYWAY RADIUS BY POLISHING OR LIGHT GRINDING. WORK IN INCREMENTS OF .020 RADIUS UP TO A MAX OF .060 RADIUS 125 RMS NOTE: CHECK OPERATION 020 FOR SIGN (CONTINUED)	M	001 MNPNA 002 05 003 MS06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	CYLINDER ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		OFF OF RED DIAGONAL. *C/P MOVE * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED*			
		HERE, TAKE PRODUCTION COUNT *			
[redacted]		HOLE AND POLISHED THREADED AREA AND KEYWAY RADIUS. NOTE: CHECK OPERATION 020 FOR SIGN	M	001 MNPNA 002 05 003 MS06	
		OFF OF RED DIAGONAL. *C/P MOVE * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED*			
		HERE, TAKE PRODUCTION COUNT *			
26 [redacted]	278	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26 [redacted]	279	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26 [redacted]	282	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
26 [redacted]	285	STRIP PISTON O.D. "NOTE" WITH THE SINGLE HOLE UP AND TORQUE ARM LUGS DOWN AND PISTON FACING			
		AWAY FROM YOU THE JOURNALS ARE NUMBERED FROM "L" TO "R" 1-3-4-2 *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	**14 NOUN**	
	CYLINDER ASSY	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26 [redacted]	300	STRIP AXLE JOURNAL #1 *C/P MOVE		001 MNPRC 002 02 003 SC02	
26 [redacted]	320	STRIP AXLE JOURNAL #2 *C/P MOVE		001 MNPRC 002 02 003 SC02	
26 [redacted]	340	STRIP AXLE JOURNAL #3 *C/P MOVE		001 MNPRC 002 02 003 SC02	
26 [redacted]	360	STRIP AXLE JOURNAL #4 *C/P MOVE		001 MNPRC 002 02 003 SC02	
8G	375	FIRST GRIND PISTON O.D. MIN OF 8.481 *C/P MOVE * * * * * * * * N O T E * * * * * * * * WITH THE SINGLE HOLE UP AND TORQUE		001 MNPRB 002 03 003 GG01	
		ARM LUGS DOWN AND PISTON FACING AWAY FROM YOU THE JOURNALS ARE NUMBERED FROM "L" TO "R" 1-3-4-2 *			
8G	390	FIRST GRIND AXLE JOURNAL #1 MIN O.D. 4.984 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GG01	
8G	405	FIRST GRIND AXLE JOURNAL #2 MIN O.D. 4.984 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GG01	
8G	420	FIRST GRIND AXLE JOURNAL #3 MIN O.D. 5.233 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GG01	
8G	435	FIRST GRIND AXLE JOURNAL #4 MIN O.D. 5.233 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GG01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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* U.S. GOVERNMENT PRINTING OFFICE: 1988—548-163

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2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	CYLINDER ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
8	450	INNER CYLINDER BORE SEAL REWORK. INNER CYLINDER DAMAGE IN SEAL AREA MAY BE HAND POLISHED OR GROUND TO A MAX. DIA I.D. OF 7.740 *C/P MOVE		001 MNPRB 002 02 003 GP01 005 X874518	
8	465	FIRST GRIND SEAL AREA I.D. TO DIM OF 7.742/7.748 *C/P MOVE		001 MNPRB 002 02 003 GP01 005 X874518	
8	480	* * * * *"OPTIONAL" HONE PISTON I.D. MAX DIM OF 7.826 * * * * *"N O T E" ONLY IF SEAL AREA I.D. DOES NOT NEED TO BE GROUND		001 MNPRB 002 01 003 HV03 005 X874524	
8	495	FIRST GRIND PISTON I.D. MAX DIM OF 7.826 *C/P MOVE		001 MNPRB 002 02 003 GP01 005 X874518	
[redacted]		ALL MACHINED AND GROUND AREAS TIME OUT_____DATE OUT_____ *C/P MOVE	M	001 MNPNA 002 06 003 TE03	
		* * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *			
26B	520	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF ETCH DATE IN TIME IN		001 MNPRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]		"NOTE" WITH THE SINGLE HOLE UP AND TORQUE	M	001 MNPNA 002 06 003 ML04	
		ARM LUGS DOWN AND PISTON FACING AWAY FROM YOU THE JOURNALS ARE NUMBERED FROM "L" TO "R" 1-3-4-2 (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	CYLINDER ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *			
		* * * * * * * * * * * * * * * * * *			
26	550	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	560	SHOT PEEN JOURNAL #1 INTENSITY OF .010/.014 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	570	SHOT PEEN JOURNAL #3 INTENSITY OF .010/.014 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	580	SHOT PEEN AXLE JOURNAL #2 INTENSITY OF .010/.014 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	590	SHOT PEEN AXLE JOURNAL #4 INTENSITY OF .010/.014 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	600	SHOT PEEN KEYWAY INTENSITY OF .010/.014 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	610	SHOT PEEN PISTON O.D. INTENSITY OF .010/.014 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	620	SHOT PEEN SEAL AREA INTENSITY .006/.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	CYLINDER ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20. "Q"
26	630	SHOT PEEN ALL REWORKED AREA INTENSITY OF .008/.014 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	635	PREPARE SEAL AREA I.D. FOR CHROME PLATE, MASK/FIXTURE/ETC. *C/P MOVE TIME IN DATE OUT		001 MNPRC 002 02 003 BE01 005 X7732114	
		MECHANIC SIGN OFF REQD			
26	640	CHROME PLATE SEAL AREA ID TYPE II CLASS 3, SUFFICIENT TO GRIND BACK TO DIM OF 7.732 TIME OUT DATE OUT		001 MNPRC 002 02 003 CP01 005 X7732114	
		MECHANIC SIGN OFF REQUIRED *C/P MOVE		008 CI010	
26B	650	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME PLATE DATE IN TIME IN		001 MNPRC 002 02 003 BK01	
		DATE OUT TIME OUT *C/P MOVE			
26	655	PREPARE PISTON O.D. FOR CHROME PLATE, MASK/FIXTURE/ETC. *C/P MOVE TIME IN DATE OUT		001 MNPRC 002 02 003 BE01 005 X7732108	
		MECHANIC SIGN OFF REQD			
26	660	CHROME PLATE PISTON OD CLASS 3 TYPE II TO SUFFICIENT TO GRIND BACK TO DIM OF 8.495/8.497 (CONTINUED)		001 MNPRC 002 02 003 CP01 005 X7732108	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		008 [illegible]/SN
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1 DATE 89046 | PAGE 1 OF 1 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	CYLINDER ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		TIME OUT_____DATE OUT_____ MECHANIC SIGN OFF REQUIRED---------> *C/P MOVE			
		"NOTE" WITH THE SINGLE HOLE UP AND TORQUE ARM LUGS DOWN AND PISTON FACING AWAY FROM YOU THE JOURNALS ARE NUMBERED FROM "L" TO "R" 1-3-4-2			
26	675	PREPARE AXLE JOURNAL #1 FOR CHROME PLATE, MASK/FIXTURE/ETC. *C/P MOVE TIME IN_____DATE OUT MECHANIC SIGN OFF REQD_____		001 MNPRC 002 02 003 BE01 005 X7732108	
26	680	CHROME PLATE AXLE JOURNAL #1 TYPE II CLASS III SUFFICIENT TO GRIND BACK TO DIM OF 4.998/4.999 TIME OUT_____DATE OUT_____ MECHANIC SIGN OFF REQUIRED---------> *C/P MOVE		001 MNPRC 002 02 003 CP01 005 X7732108 008 CC020	
26	690	PREPARE AXLE JOURNAL #3 FOR CHROME PLATE, MASK/FIXTURE/ETC. *C/P MOVE TIME IN_____DATE OUT MECHANIC SIGN OFF REQD_____		001 MNPRC 002 02 003 BE01 005 X7732108	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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1 DATE 89046 [redacted] PAGE __ OF __ PAGES

2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	CYLINDER ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	700	CHROME PLATE AXLE JOURNAL #3 TYPE II CLASS III SUFFICIENT TO GRIND BACK TO DIM OF 5.248/5.249		001 MNPRC 002 02 003 CP01 005 X773210	
		TIME OUT_____DATE OUT_____ MECHANIC SIGN OFF REQUIRED----------> *C/P MOVE		008 C0030	
26	720	PREPARE AXLE JOURNAL #2 FOR CHROME PLATE, MASK/FIXTURE/ETC. *C/P MOVE TIME IN_____DATE OUT		001 MNPRC 002 02 003 BE01 005 X773210	
		MECHANIC SIGN OFF REQD_____			
26	740	CHROME PLATE AXLE JOURNAL #2 TYPE II CLASS III SUFFICIENT TO GRIND BACK TO DIM OF 4.998/4.999		001 MNPRC 002 02 003 CP01 005 X773210	
		TIME OUT_____DATE OUT_____ MECHANIC SIGN OFF REQUIRED----------> *C/P MOVE		008 C0040	
26	750	PREPARE AXLE JOURNAL #4 FOR CHROME PLATE, MASK/FIXTURE/ETC. *C/P MOVE TIME IN_____DATE OUT		001 MNPRC 002 02 003 BE01 005 X773210	
		MECHANIC SIGN OFF REQD_____			
26	760	CHROME PLATE AXLE JOURNAL #4 TYPE II CLASS III SUFFICIENT TO GRIND BACK TO DIM OF 5.248/5.249		001 MNPRC 002 02 003 CP01 005 X7732108	
		TIME OUT_____DATE OUT_____ MECHANIC SIGN OFF REQUIRED----------> *C/P MOVE		008 C0050	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	CYLINDER ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
26B	780	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME PLATE DATE IN _____ TIME IN _____		001 MNPRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
8G	790	FINISH GRIND PISTON O.D. FINISH GRIND TO DIM OF 8.495/8.497 16/32 RMS *C/P MOVE		001 MNPRB 002 03 003 GG01	
		"NOTE" WITH THE SINGLE HOLE UP AND TORQUE ARM LUGS DOWN AND PISTON FACING AWAY FROM YOU THE JOURNALS ARE			
		NUMBERED FROM "L" TO "R" 1-3-4-2			
8G	800	FINISH GRIND AXLE JOURNAL #1 FINISH GRIND TO DIM OF 4.998/4.999 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GG01	
8G	810	FINISH GRIND AXLE JOURNAL #2 FINISH GRIND TO DIM OF 4.998/4.999 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GG01	
8G	820	FINISH GRIND AXLE JOURNAL #3 FINISH GRIND TO DIM OF 5.248/5.249 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GG01	
8G	830	FINISH GRIND AXLE JOURNAL #4 FINISH GRIND TO DIM OF 5.248/5.249 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GG01	
8	840	FINISH GRIND I.D. SEAL AREA FINISH DIM OF 7.732/7.735 63 RMS *C/P MOVE		001 MNPRB 002 02 003 GP01 005 X8745180	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	CYLINDER ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26B	880	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____		001 MNPRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	
26	895	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
[redacted]		*C/P MOVE * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ZS01	
26	902	ABRASIVE BLAST WELD SPATTER BELOW INNER SEAL AREA 300% COVERAGE *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	905	BLAST TO REMOVE RUST OR CORROSION ON I.D. OF AXLE BEFOR CAD PLATE *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	907	PRIOR TO CAD/IVD PLATE, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED. *C/P MOVE		001 MNPRC 002 01 003 BL02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	CYLINDER ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	910	CAD PLATE CLASS I TYPE II 7.6 SQ FT AT 380-532 AMPS TIME OUT DATE OUT		001 MNPRC 002 03 003 CAD1	
		*C/P MOVE			
26B	920	BAKE 23 HRS AT 350-400F WITHIN 4 HRS OF CAD PLATING DATE IN TIME IN		001 MNPRC 002 02 003 BK01	
		DATE OUT TIME IN *C/P MOVE			
26	930	IRIDITE *C/P MOVE		001 MNPRC 002 02 003 IR01	
[redacted]	.65	*C/P MOVE * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	
26	937	VAC I.V.D. ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 920 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE		001 MNPRC 002 03 003 IV01	
26	939	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNPRC 002 03 003 TA01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN	
	CYLINDER ASSY	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED.	18. MECHANIC	19. "P"	20. "Q"
69	940	JACK PAD BOSS STEEL INSERT. THIS IS DONE ONLY WHEN SHIM WAS INSERTED IN JACK PAD HOUSING. MAKE STEEL INSERT IAW BOEING DRAWING 36-7090-1		001 MNPRA 002 03 003 LE02	
		125 RMS *C/P MOVE P/N 367090-1			
69	945	INSTALL JACK PAD BOSS STEEL INSERT IAW DWG 36-7090-1		001 MNPRA 002 03 003 BE01	
69	949	MACHINE BUSHING O.D. TO FIT TORQUE ARM ATTACHING LUG .002 PRESS FIT *C/P MOVE P/N 68C29160-25		001 MNPRA 002 03 003 LE02	
69	950	TORQUE ARM ATTACHING LUG BUSHING INSTALLATION. INSTALL PRESS FIT TO .001/.003 FINISH LINE REAM TO DIM OF 1.751/1.752		001 MNPRA 002 03 003 RE01	
		125 RMS *C/P MOVE			
69	959	MACHINE BUSHING O.D. TO FIT TOW LUG, PRESS FIT .001/.002 *C/P MOVE P/N 66C33000-03501		001 MNPRA 002 03 003 LE02	
		P/N 6-71444			
69	960	TOW LUG BUSHING INSTALLATION OR PRESS FIT .001/.002 FINISH LINE REAM TO .515/.535 125 RMS *C/P MOVE		001 MNPRA 002 03 003 BE01	
34PP	990 *REQD*	PAINT WELD SPLATTER WITH 2 EA COATS OF POLYURETHANE PRIMER & 2 COATS OF POLYURETHANE PAINT *C/P MOVE		001 MNPGP 002 09 003 PP01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16002N
		B	D	

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AFLC FORM 958 NOV 80 PREVIOUS EDITION WILL BE USED

☆ U.S. GOVERNMENT PRINTING OFFICE: 1986—646-163

16002N **WORK CONTROL DOCUMENT (MEDS)**

DATE [redacted] PAGE [redacted] OF [redacted] PAGES

2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	CYLINDER ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	995	FINAL ACCEPTANCE OF WORK CONTROL		001 MNP	GP
		DOCUMENT FOR COMPLETENESS & ACCURACY		002 06	
	REQD	OF ALL PRECEDING OPERATIONS THIS 995		003 SA	03
[redacted]	996	FINAL PRODUCT VISUAL INSPECTION		001 MNP	GP
		* C/P MOVE		002 06	
	REQD			003 SA	03

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16002N
		B	D	

AFLC FORM 950 NOV. 80

PREVIOUS EDITIONS OBSOLETE

☆ U.S. GOVERNMENT PRINTING OFFICE: 1980—646-163

16010N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89046 | PAGE 1 OF ___ PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
		MNPGP		

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO
	1. 4S-1-182 2. 4S1-57-3	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
B-52 MAIN		17142A

13. SERIAL NUMBER	14 NOUN
	CENTERING CAM ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 25-4214-501		NSN [redacted] C/N 17142A [redacted] 17261A			
		****** UNIT COST: $774.00 ********			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		FMPI IAW MIL-STD-1949			
		P/O NO1561			
		BAKE IAW 4S-1-182 MAOI 74-12			
		SILVER PLATE IAW QQ-S-365			
		PHOSPHATE COAT IAW DOD-P-16232			
		BLAST IAW MIL-STD-1504			
		STRIP SILVER IAW MIL-STD-871			
		**********STEEL**********			
		**********180,000/200,000**********			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16010N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1989—640-163

16010N WORK CONTROL DOCUMENT (MEDS) [redacted] PAGE __ OF __ PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	CENTERING CAM ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN			
		COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	25-4214-501			
[redacted]	*REQD*	DISASSEMBLE *C/P MOVE		001 MNPGW 002 02 003 MD03 005 X874523	
				006 X874525	
[redacted]	*REQD*	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 SL01	
[redacted]	*REQD*	BLAST CLEAN ONLY *C/P MOVE		001 MNPGW 002 03 003 BL01	
[redacted]	*REQD*	BAKE 4 HRS AT 350-400F DATE IN_____TIME IN_____		001 MNPGW 002 03 003 BK03	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]	*REQD*	NOTE: IF CRACKED RECHECK ON OPERATION 130 AFTER MACHINING (CONTINUED)	M	001 MNPNA 002 05 003 MS03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16010N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1988—548-143

16010N **WORK CONTROL DOCUMENT (MEDS)**

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	CENTERING CAM ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		OPERATION. *C/P MOVE~~INSPECTION~~			
[redacted]		E AND I INSPECTION IAW 2-21-14, PAGE 2-24B		001 MNPGW 002 04	
	REQI	*C/P MOVE		003 EI01	
26	070	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	080	STRIP SILVER FROM FACE OF CAMS *C/P MOVE		001 MNPRC 002 03 003 SS01	
69	100	CENTERING CAM KEY REPAIR IAW FIG 2-25 MACHINE A 45 CHAMFER 1/4 TO 3/8 IN LONG ON SILVER PLATED END OF LOWER CAM KEYS		001 MNPRA 002 03 003 BE01	
		*C/P MOVE			
69	105	CENTERING CAM KEY REPAIR IAW FIG 2-25 MACHINE A RADIUS ON KEYS OF LOWER & UPPER CAM TO REMOVE CRACK *C/P MOVE		001 MNPRA 002 03 003 BE01	
69	110	ELECTRO ETCH INDEX MARKS TO INDICATE POSITION TO MAX DEPTH .0002 RENUMBER LOWER CAM TO P/N 25-4214-501 *C/P MOVE		001 MNPRA 002 03 003 BE01	
[redacted]		*C/P MOVE		001 MNPNA	
		* * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *	M	002 06 003 ML04	
		* * * * * * * * * * * * * * * * * * * *			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16010N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-143

16010N WORK CONTROL DOCUMENT (MEDS) [redacted] PAGE 2 OF [redacted] PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	CENTERING CAM ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	132	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	134	PREPARE FOR SILVER PLATE, MASK/ FIXTURE/ETC. *C/P MOVE		001 MNPRC 002 03 003 BE01	
26	136	PREPARE FOR SILVER PLATE, GRIT BLAST ALL AREAS TO BE SILVER PLATED. *C/P MOVE		001 MNPRC 002 01 003 BL04	
26	140	SILVER PLATE FACE OF LOWER CAM .0004/.0006 THICK TIME OUT_____DATE OUT_____ *C/P MOVE		001 MNPRC 002 03 003 SI01	
26B	150	BAKE (48) HRS 350-400F WITHIN 4 HRS OF SILVER PLATING DATE IN_____TIME IN_____		001 MNPRC 002 02 003 BK02	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
26	155	PRIOR TO PHOSPHATE COAT, GRIT BLAST ALL AREAS TO BE PHOSPHATE COATED. *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	170	PHOSPHATE COAT TYPE M . ***NOTE: DO NOT PLATE FACES**** .		001 MNPRC 002 03 003 PH01	
		TIME OUT_____DATE OUT_____ *C/P MOVE			
26B	180	BAKE 8 HRS AT 210-225F AFTER COATING . DATE IN_____TIME IN_____ (CONTINUED)		001 MNPRC 002 02 003 BK02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16010N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-163

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2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	CENTERING CAM ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]	230 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 953		001 MN 002 06 003 SA	PGP 03
[redacted]	240 *REQD*	FINAL PRODUCT VISUAL INSPECTION * C/P MOVE		001 MN 002 06 003 SA	PGP 03

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16010N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE [redacted]

16013N

WORK CONTROL DOCUMENT (MEDS)

[redacted] DATE [redacted] 89042 PAGE [redacted] OF [redacted] PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	401-57-1 AS-1-182	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
F-5? MAIN		
13. SERIAL NUMBER	**14. NOUN**	
	CAP ASSY TRUNNION	17142A

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 9-52976 / 52977	I.B. O.B.	NSN [redacted] 1620003270506 C/N [redacted]			
		[illegible]			
		[illegible]			
		[illegible]			
		[illegible]			
		ALL [illegible] PROJECT [illegible] IN [illegible] HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY			
		PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL			
		ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16013N
		B	D	

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16013N

WORK CONTROL DOCUMENT (MEDS)

1. DATE 89046 | PAGE 2 OF 4 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	CAP ASSY TRUNNION

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		MANY OF THE [illegible] PRECEDE [illegible] SOLVENT [illegible]			
		WHILE ANY "OUTSIDE" PARTS ARE PERSONNEL, ASSOCIATE [illegible] PRECAUTIONS MUST BE TAKEN TO PRECLUDE [illegible]			
		REQUIRE [illegible] CLEAN [illegible] STAMP.			
	001	9-50 [illegible]			
[redacted]	*REQD*	DISASSEMBLE [illegible]		001 MNP GW	
[redacted]	*REQD*	CHEM [illegible]		002 03 003 SL01	
[redacted]	*REQD*	BLAST CLEAN ONLY [illegible]		001 MNP GW 002 03 003 BL07	
[redacted]	*REQD*	BAKE 4 HRS AT 250/400F DATE IN: _____ TIME IN: _____		001 MNP GW 002 03 003 BK03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
				16013N
		B	D	

★ U.S. GOVERNMENT PRINTING OFFICE: 1988—548-163

16013N

WORK CONTROL DOCUMENT (MEDS)

1 DATE	PAGE 1 OF 1 PAGES
89046	

2 JOB ORDER NO	3 QUANTITY	PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	CAP, NOSE [illegible]

15. DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "C"
		DATE OUT:_____ TIME OUT:_____			
[redacted]	[illegible]	[illegible]		[illegible]	
[redacted]	[illegible]	[illegible]		001 MNFRW 002 04 003 E101	
		[illegible]			
		[illegible]			
		[illegible]			
		[illegible]		[illegible]	
		[illegible]		[illegible]	
26	027	STRIP RUST *C/P MOVE		001 MNFRC 002 02 003 CS02	
25	030	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		001 MNFRC 002 01 003 BL02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16013N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

☆ U.S. GOVERNMENT PRINTING OFFICE: 1980—640-163

16013N

WORK CONTROL DOCUMENT (MEDS)

1 DATE: 89046

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	CAP ASSY TRUNNION

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	040	CAD PLATE TYPE II CLASS 1 I.D. AND OUTSIDE FACES ONLY TIME OUT ___ DATE OUT ___		001 MNF 002 03 003 CA0	RC 1
26A	03[illegible]	BAKE 23 HRS WITHIN [illegible] [illegible]		001 MNF 002 02 003 BK0	RC 1
		DATE IN ___ TIME IN ___ DATE OUT ___ TIME OUT			
26	[illegible]	INSPECT *C/P MOVE		001 MNF 002 [illegible] 003 [illegible]	RC 1
[redacted]		*C/P [illegible] [illegible] [illegible]		001 M[illegible] 002 03 003 ML0	RC 4
.65		[illegible] * * * * * * * * * * * * * * * * * *			
26	0[illegible]	[illegible] [illegible] OPERATION [illegible] ACCOMPLISHED [illegible]		[illegible]	[illegible]
		[illegible] *C/P MOVE			
26	049	ALODINE I.D. ALUM PLATE CLASS [illegible] *C/P MOVE		001 MNF 002 03 003 IA0	RC 1
26BP	050	BRUSH PLATE I.D. OF BEARING CAPS WITH THE CAD I.D. & OUTSIDE FACES ONLY *C/P MOVE		001 MNF 002 02 003 BP0	RC 1

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16013N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1986—[illegible]

16013N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89046 PAGE 5 OF 5 PAGES

2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 'OPTIONAL

13. SERIAL NUMBER	14 NOUN
	CAP ASSY TRUNNION

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	060 PREFICK	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PREVIOUS OPERATIONS THIS SEC		001 MNP 002 06 003 SA03	GP
[redacted]	070 PREWIT	FINAL PRODUCT [illegible]		[illegible]	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16013N
		B	D	

16014N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89046 | PAGE 1 OF ___ PAGES

2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED.	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	1. 4S-1-182	

10 MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
P-52 MAIN		

13. SERIAL NUMBER	14 NOUN
	NUT, RETAINER UPPER BEARING

17142A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 3-80736-3		NSN [redacted] C/N 17142A			
		[illegible]			
		[illegible]			
		[illegible]			
		[illegible]			
		[illegible]			
		[illegible]			
		[illegible]			
		[illegible]			
		THE BASIC TECHNICAL ORDER & T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPER/DISPATCH STATIONS			
		WARNING			

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16014N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1988—548-163

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2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14. NOUN
	NUT, RETAINER UPPER OLEO BRG

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS			
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURY.			
		*REQUIR (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO [illegible] STAMP			
	001	3-007.W 3			
[redacted]	[redacted]	DISASSEMBLE		001 MNP W 002 02 003 MIO7	
	*P+001			004 XR 45250	
				005 XR 45251 006 XR 45252	
[redacted]	[redacted]	CHEM CLEAN *C/P MOVE		001 [illegible] W 002 03 003 [illegible]	
	REQ 1				
[redacted]	[redacted]	PLASMA [illegible]		001 [illegible] W 002 03 003 BL07	
	REQ0P				
[redacted]	[redacted]	BAKE 4 HRS AT 350-400F		001 MNP W 002 03 003 BK03	
	REQ0	DATE IN ___ TIME IN ___			
		DATE OUT ___ TIME OUT ___ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16014N
		B	D	

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WORK CONTROL DOCUMENT (MEDS)

16014N

1. DATE 89046

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2. JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	[illegible]

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q
[redacted]	[illegible]	(((NOTE))) IF LEAKED CONDEMN [illegible]	M	001 MNPNA 002 05 003 MS03	
[redacted]	[illegible]	[illegible]		[illegible]	
69	023	MACHINE TO REMOVE BOTTOM PART APROX [illegible]		[illegible]	
		[illegible]		[illegible]	
[redacted]		IF LEAK REMOV [illegible]	M	001 MNPNA 002 05 003 MS03	
		********** NOTE ********** IF LEAK NOT CORRECTED [illegible]			
[illegible]	[illegible]	[illegible]		[illegible]	
[illegible]	030	STRIP COATING *C/P MOVE		001 MNHRL 002 02 003 CS01	
24	035	STRIP RUST *C/P MOVE		001 MNHRC 002 02 003 CS02	
268	040	BAKE 4 HRS @ 375-400F AFTER STRIP DATE IN ..... TIME IN		001 MNHRC 002 02 003 BK01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
				16014N
		B	D	

★ U.S. GOVERNMENT PRINTING OFFICE: 1989—649-183

16014N **WORK CONTROL DOCUMENT (MEDS)** 1 DATE 89046 PAGE 1 OF ___ PAGE

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	MAT'L REQ'D(NCP UPPER SLIDE ASS

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q
		[illegible] LAP [illegible]			
[redacted]		[illegible]		[illegible]	
		********** DO NOT ********** IF LAST MFG OPERATION IS COMPLETED PLACE YOUR PRODUCTION COUNT **********			
[illegible]	[illegible]	W/C [illegible] C/P MOVE		[illegible]	
[illegible]	[illegible]	[illegible] SPRINGER SLIDE INSERTS [illegible] C/P MOVE		[illegible]	
[illegible]	[illegible]	PRIOR TO LAP PLATE, GRIT BLAST ALL [illegible] C/P MOVE		[illegible]	
[illegible]	[illegible]	[illegible]		[illegible]	
[illegible]	[illegible]	[illegible] OF LAP		[illegible]	
		DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____			
[redacted]	.65	C/P MOVE (IF CRACKED CONDEMN) *C/P MOVE	M	001 MNFNA 002 06 003 ML04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
				16014N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1988—548-163

16014N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89046 PAGE 5 OF 5 PAGES

2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	NUT, RETAINER UPPER BULK HEAD

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		* * * * * * * N O T E * * * * * * * IF LAST NO1 OPERATION IS COMPLETED* [illegible]			
		[illegible]			
		[illegible]			
		[illegible]			
		[illegible]			
		[illegible]			
		[illegible]			
		[illegible]			
		[illegible]			
		[illegible]			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16014N
		B	D	

★ U.S. GOVERNMENT PRINTING OFFICE: 1988—549-163

16004N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89089 | PAGE 1 OF PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.
	4S-1-182 4S1-57-3	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
B-52 MAIN		

13. SERIAL NUMBER	14 NOUN
	STEERING BEARING ASSY (M)

17142A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
9-52299-505		UPPER: 1620[illegible] 17142A			
9-52532-501		[illegible]			
		**** UNIT COST: $195.97/$477.56****			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		BLAST IAW MIL-STD-1504			
		CAD PLATE IAW MIL-STD-870 BRUSH PLATE IAW MIL-STD-865 4S-1-182 STRIP IAW MIL-STD-871			
		IVD ALUM PLATE IAW MIL-C-83488A ALODINE IAW MIL-C-5541			
		********** BRASS **********			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY			
		PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS			
		WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR			
		MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. WARNING MANY OF THE FOLLOWING REPAIR			
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO (CONTINUED)			

21 FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16004N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

☆ U.S. GOVERNMENT PRINTING OFFICE: 1988—548-163

16004N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89089 PAGE 2 OF __ PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	STEERING BEARING ASSY (M)

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PERSONNEL. ADEQUATE SAFEGUARDS AND PRECUATIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	9-52299-505 9-52533-501			
[redacted]	*REQD*	DISASSEMBLE *C/P MOVE		001 MNPGW 002 02 003 MD03 005 X8745234	
				006 X8745250	
[redacted]	*REQD*	DEGREASE ONLY *C/P MOVE		001 MNPGW 002 02 003 DG02	
[redacted]	*REQD*	BLAST CLEAN ONLY *C/P MOVE		001 MNPGW 002 03 003 BL07	
[redacted]	*REQD*	E & I INSPECTION BEARING WIDTH 1.495/1.506 *C/P MOVE		001 MNPGW 002 04 003 EI01	
26	015	STRIP CAD PLATE *C/P MOVE		001 MNPRC 002 02 003 CS01	
69	020	STEERING BEARING HOLE REPAIR. INSTALL IN JIG AND DRILL 12 HOLES I.D. .191/.1945 COUNTERSINK HOLES (CONTINUED)		001 MNPRA 002 04 003 DP03 005 X8745619	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16004N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1988—548-163

16004N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89089 | PAGE 3 OF ___ PAGES

2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	STEERING BEARING ASSY (M)

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		100 DEGREES TO A DIA. OF .400/.430 *C/P MOVE			
		(NOTE ASSEMBLED ON STRUT FOR O/S) 1ST OVERSIZE STEERING BEARING HOLE REPAIR. DRILL HOLES OVERSIZE TO			
		CLEANUP .208 MAX. COUNTERSINK HOLES 100 DEGREES TO A DIA OF .400/.430 (NOTE ASSEMBLED ON STRUT FOR O/S)			
		2ND OVERSIZE STEERING BEARING HOLE REPAIR. DRILL HOLES OVERSIZE TO CLEANUP .230 MAX. COUNTERSINK HOLES			
69	080	STEERING BEARING END RADIUS AND CHAMFER. RADIUS CHAMFER IAW FIG 2-30. ELECTRO ETCH OR METAL STAMP AS PER NOTE 2. * C/P MOVE		001 MNPRA 002 04 003 BE01	
26	083	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	087	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	090	CAD PLATE TYPE II CLASS I .47 SQ FT AT 23.5-32.9 AMPS TIME IN_____DATE IN_____ *C/P MOVE		001 MNPRC 002 03 003 CA01	
26BP	100	CAD PLATE BEARING BRUSH CAD PLATE .47 SQ FT AT 23.5-32.9 AMPS *C/P MOVE		001 MNPRC 002 02 003 BP01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16004N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1985—546-153

16004N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89089 — PAGE 4 OF 4 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	STEERING BEARING ASSY (M)

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
26	120	IRIDITE (CHROME CONVERSION COATING) *C/P MOVE		001 MNPRC 002 02 003 IR01	
26	125	VAC IVD ALUM PLATE CLASS 2 TYPE II *C/P MOVE		001 MNPRC 002 03 003 IV01	
26	130	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNPRC 002 03 003 TA01	
[redacted]	140	CHANGE P/N IAW FIG 2-30 *C/P MOVE		001 MNPGP 002 06 003 FA08	
69	160	INSTALL AND MATCH DRILL GEAR QUADRANT, P/N 9-52273 IAW PARA 2-62 AND FIG 2-30 PAGES 2-64-65 OF T.O. *C/P MOVE		001 MNPKA 002 04 003 BE01	
		P/N 9-52273 P/N MS20426DD5-6 P/N MS2042605-6			
[redacted]	190 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 95[illegible]		001 MNPGP 002 06 003 FA08	
[redacted]	200 *REQD*	FINAL PRODUCT VISUAL INSPECTION * C/P MOVE		001 MNPGP 002 06 003 FA08	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16004N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1988—548-163

16005N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89046 — PAGE 1 OF ___ PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
		MNPOP		

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.
	4S-1-182 4S1-57-3	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
B-52 MAIN		

13. SERIAL NUMBER	14 NOUN
	LOWER TRIPOD LINK

17142A

15. DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
P/N 25-4211		NSN [redacted] C/N 17142A 17143A 90400A			
		******* UNIT COST: $462.00 ******* GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 C.M.P.I. IAW MIL-STD-1949 P/O N01561			
		CAD PLATE IAW MIL-STD-870 BLAST IAW MIL-STD-1504 IVD ALUM PLATE IAW MIL-C-83488A			
		ALODINE IAW MIL-C-5541 BAKE IAW 4S-1-182 MAOI 74-12 *****STEEL 220,000/240,000 PSI******			
		ALL PRESONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMNET HAVE BEEN THOROUGHLY TRAINED AND ARE			
		FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE			
		APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY			
		CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16005N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE 1983—646-183

16005N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89046 | PAGE 2 OF 2 PAGES

2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	LOWER TRIPOD LINK

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	25-4211			
[redacted]	*REQD*	DISASSEMBLE *C/P MOVE NOTE: REMOVE ALL BUSHINGS.		001 MNPGW 002 02 003 MD03 005 X874523 006 X874525	
[redacted]	*REQD*	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 SL01	
[redacted]	*REQD*	BLAST CLEAN ONLY *C/P MOVE		001 MNPGW 002 03 003 BL01	
[redacted]	*REQD*	BAKE 4 HRS AT 350-400F DATE IN_____TIME IN_____ DATE OUT_____TIME OUT_____ *C/P MOVE		001 MNPGW 002 03 003 BK03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16005N
		B	D	

AFLC FORM 668 NOV. 80 PREVIOUS EDITION WILL BE USED

☆ U.S. GOVERNMENT PRINTING OFFICE: 1988—548-163

16005N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89044 | PAGE 8 OF PAGE

2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	LOWER TRIPOD LINK

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "C"
[redacted]	*REQD*	*C/P MOVE	M	001 MNPNA 002 05 003 MS03	
[redacted]	*REQD*	E & I INSPECTION LUG (G) I.D. 1.625/1.626 WEAR 1.627		001 MNPGW 002 04 003 EI01	
		LUG (H) I.D. 1.625/1.626 WEAR 1.627 ********** N O T E ********** * A MINIMUM OF AT LEAST TWO FMPI'S * * IS REQUIRED. *			
		********** *C/P MOVE			
[redacted]	*REQD*	ANY LINK UNDER 200 KSI/ROCKWELL C-43 WILL BE CONDEMNED RECORD HARDNESS		001 MNPWW 002 03 003 TR15	
		*C/P MOVE			
69	070	REMOVE BUSHINGS STA 34 CAN NOT REMOVE *C/P MOVE		001 MNPRA 002 03 003 BE01	
69	100	MACHINE LUG (G) OVERSIZE TO CLEANUP MAX I.D. 1.685/1.725 *C/P MOVE		001 MNPRA 002 03 003 MH06	
69	120	MACHINE LUG (H) OVERSIZE TO CLEANUP MAX I.D. 1.685/1.725 *C/P MOVE		001 MNPRA 002 03 003 MH06	
26	123	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16005N
		B	D	

AFLC FORM 958 NOV. 80

☆ U.S. GOVERNMENT PRINTING OFFICE: 1980—640-164

16005N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89046 | PAGE 4 OF PAGES

2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	LOWER TRIPOD LINK

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
26 [redacted]	127	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26 [redacted]	130	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
26 [redacted]	135	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		001 MNPRC 002 01 003 BL02	
26 [redacted]	140	CAD PLATE TYPE II CLASS 1 4.5 SQ FT AT 225-315 AMPS TIME OUT DATE OUT		001 MNPRC 002 03 003 CA01	
		*C/P MOVE			
26B [redacted]	160	BAKE 23 HRS AT 350-400F WITHIN 4 HRS OF CAD DATE IN TIME IN		001 MNPRC 002 02 003 BK01	
		DATE OUT ..... TIME OUT ..... *C/P MOVE			
26 [redacted]	200	IRIDITE *C/P MOVE		001 MNPRC 002 02 003 IR01	
[redacted]	165	*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *	M	001 MNPNA 002 06 003 ML04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16005N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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☆ U.S. GOVERNMENT PRINTING OFFICE: 1980—346-104

16005N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89046 | PAGE __ OF __ PAGES

2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	LOWER TRIPOD LINK

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26 [redacted]	213	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 160 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION.		001 MNPRC 002 03 003 IV01	
		*C/P MOVE			
26 [redacted]	217	ALODINE IVD ALUM PLATE CLAS 1A *C/P MOVE		001 MNPRC 002 03 003 TA01	
69	219	MACHINE LOWER LINK LUG G BUSHING O.D TO FIT HOLE .0005/.0015 PRESS FIT *C/P MOVE P/N 68C29160-13		001 MNPRA 002 03 003 LE02	
		P/N 68C29160-15			
69	220	LOWER LINK LUG (G) BUSHING INSTALLATION 68C29160-13 OR -15 PRESS FIT .0005/.0015		001 MNPRA 002 03 003 BE01	
69	225	FINISH LINE REAM OR HONE ID 1.625/1.626 NOTE: BUSHING WALL THICKNESS MUST NOT BE LESS THAN .030 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNPRA 002 03 003 MH06	
69	235	MACHINE LOWER LINK LUG (H) BUSHING, O.D. TO FIT HOLE .0005/.0015 PRESS FIT *C/P MOVE P/N 68C29160-17		001 MNPRA 002 03 003 LE02	
69	240	LOWER LINK LUG (H) BUSHING INSTALLATION 68C29160-17 PRESS FIT .0005/.0015 (CONTINUED)		001 MNPRA 002 03 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16005N
		B	D	

AFLC FORM 988 NOV. 80

☆ U.S. GOVERNMENT PRINTING OFFICE: 1980—640-184

16005N WORK CONTROL DOCUMENT (MEDS)

1 DATE 87046 | PAGE 6 OF 6 PAGES

2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	LOWER TRIPOD LINK

15. DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		NOTE: BUSHING OF WALL THICKNESS MUST NOT BE LESS THAN .030 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED			
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
69	245	FINISH LINE REAM OR HONE I.D. OF LOWER LINK LUG (H) BUSHING 1.625/1.626 *C/P MOVE		001 MNPRA 002 03 003 MH06	
[redacted]	270 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 95[illegible]		001 MNPGP 002 06 003 FA08	
[redacted]	280 *REQD*	FINAL PRODUCT VISUAL INSPECTION * C/P MOVE		001 MNPGP 002 06 003 FA08	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16005N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

8

* U.S. GOVERNMENT PRINTING AND OFFICE: 1980—340-100

16006N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89046 | PAGE [illegible] OF [illegible] PAGES

2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
		MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	1. 4S-1-182 2. 4S1-57-3	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
B-52 MAIN		
13 SERIAL NUMBER	**14 NOUN**	
	LINK, DRAG STRUT O/B TRIPOD	17142A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
5-36035-3		1620006207642 17142A			
5-36035-2		N.S.L. 17143A			
		******* UNIT COST: $751.70 *******			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		FMPI IAW MIL-STD-1949			
		P/O N01561			
		CAD PLATE IAW MIL-STD-870			
		BLAST IAW MIL-STD-1504			
		BAKE IAW 4S-1-182			
		MAOI 74-12			
		VAC IVD ALUM PLATE IAW MIL-C-83488A			
		ALODINE IAW MIL-C-5541			
		********180,000/200,000 PSI********			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOUCMENT HAVE BEEN THOROUGHLY TRAINED AND ARE			
		FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE			
		APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY			
		CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING			
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16006N
		B	D	

AFLC FORM 958 NOV. 80 — PREVIOUS EDITION WILL BE USED

☆ U.S. GOVERNMENT PRINTING OFFICE: 1988—548-163

16006N **WORK CONTROL DOCUMENT (MEDS)**

1. DATE 8904 | PAGE 2 OF [redacted] PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	LINK, DRAG STRUT O/B TRIPOD

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) SERVES THE SAME PURPOSE AS DELTA STAMP IN BLOCK 16			
	001	5-36035-2 5-36035-3			
[redacted]	*REQD*	DISASSEMBLE *C/P MOVE NOTE: REMOVE ALL BUSHINGS.		001 MNPGW 002 02 003 MD03 005 X8745234	
				006 X8745250	
[redacted]	*REQD*	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 SL01	
[redacted]	*REQD*	BLAST CLEAN ONLY *C/P MOVE		001 MNPGW 002 03 003 BL01	
[redacted]	*REQD*	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____		001 MNPGW 002 03 003 BK03	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
[redacted]	*REQD*	*C/P MOVE	M	001 MNPNA 002 05 003 MS03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16006N
		B	D	

AFLC FORM 858 NOV. 80 PREVIOUS EDITION WILL BE USED

8

* U.S. GOVERNMENT PRINTING OFFICE: 1980—348-104

16006N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89046 | PAGE 3 OF *PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7 PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	LINK, DRAG STRUT O/B TRIPOD

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		E AND I INSPECTION		001 MNPGW	
				002 04	
	REQD	LUG (A) 1.250/1.251 WEAR 1.252		003 EI01	
		LUG (B) 1.625/1.626 WEAR 1.627			
		LUG (C) 2.000/2.001 WEAR 2.002			
		LUG (D) 1.250/1.251 WEAR 1.252			
		********** N O T E **********			
		* A MINIMUM OF AT LEAST TWO FMPI'S *			
		* IS REQUIRED. *			
		**********			
		*C/P MOVE			
69	080	REMOVE BUSHINGS STA 34 COULD NOT		001 MNPRA	
		*C/P MOVE		002 03	
				003 BE01	
69	100	OVERSIZE REPAIR LUG (A) .015 MIN		001 MNPRA	
		WALL BUSHING		002 03	
				003 MV00	
		ONE SIDE .590 OPPOSITE SIDE .590		005 X863362	
		MIN WALL			
		ONE SIDE .585 OPPOSITE SIDE .600			
		MIN WALL			
		ONE SIDE .580 OPPOSITE SIDE .610			
		MIN WALL			
		*C/P MOVE			
69	120	OVERSIZE REPAIR LUG (B) MACHINE TO		001 MNPRA	
		CLEANUP I.D. 1.685/1.705		002 03	
		*C/P MOVE		003 MV00	
				005 X863362	
69	140	OVERSIZE REPAIR LUG (C) MACHINE TO		001 MNPRA	
		CLEANUP I.D. 2.060/2.100		002 03	
		*C/P MOVE		003 MV00	
				005 X863362	

21. FINAL DESTINATION	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/CN
		A	C	16006N
		B	D	

PREVIOUS EDITION WILL BE USED

16006N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89046 | PAGE 4 OF PAGES

2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	LINK, DRAG STRUT O/B TRIPOD

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	160	OVERSIZE REPAIR LUG (D) MACHINE TO CLEANUP I.D. 1.310/1.350 *C/P MOVE		001 MNPRA 002 03 003 MVD0 005 X843362	
26	163	DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	167	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	170	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
26	175	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	180	CAD PLATE TYPE II CLASS I 3.3 SQ FT AT 165-231 AMPS TIME OUT DATE OUT *C/P MOVE		001 MNPRC 002 03 003 CA01	
26B	200	BAKE 23 HRS AT 350-400F WITHIN 4 HRS OF CAD DATE IN TIME IN DATE OUT TIME OUT *C/P MOVE		001 MNPRC 002 02 003 BK01	
26	240	IRIDITE *C/P MOVE		001 MNPRC 002 02 003 IR01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16006N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1988—548-154

16006N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89046 | PAGE 5 OF ___ PAGES

2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	LINK, DRAG STRUT O/B TRIPOD

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	[redacted]			001 MNPNA	
	.65	*C/P MOVE	M	002 06	
		* * * * * * * * N O T E * * * * * * * *	*	003 ML04	
		IF LAST NDI OPERATION IS COMPLETED	*		
		HERE, TAKE PRODUCTION COUNT	*		
		* * * * * * * * * * * * * * * * * *	*		
26	253	VAC IVD ALUM PLATE CLASS 2 TYPE 1/		001 MNPRC	
		NOTE: OPERATION 200 MUST BE		002 03	
		ACCOMPLISHED IF PRIOR PLAING REWORK		003 IV01	
		IS DONE, BEFORE USING IVD OPTION.			
		*C/P MOVE			
26	257	ALODINE IVD ALUM PLATE CLASS 1A		001 MNPRC	
		*C/P MOVE		002 03	
				003 TA01	
69	259	MACHINE LUG (B) BUSHING O.D. TO FIT		001 MNPRA	
		HOLE .0005/.0015 PRESS FIT		002 03	
		*C/P MOVE		003 LE02	
		P/N 68C29160-01			
		P/N 68C29160-15			
69	260	LUG (B) BUSHING INSTALLATION. P/N		001 MNPRA	
		68C29160-01 OR -15. PRESS FIT		002 03	
		.0005/.0015 FINISH HONE BUSHINGS		003 BE01	
		I.D. 1.625/1.626			
		NOTE: BUSHING WALL THICKNESS MUST			
		NOT BE LESS THAN .030			
		RECORD WEAR DIM IF REWORK LIMITS ARE			
		EXCEEDED_____			
		RECORD REASON & CAUSE FOR EXCEEDING			
		REWORK LIMITS_____			
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16006N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1985—646-142

16006N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89046 | PAGE 6 OF PAGES

2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	LINK, DRAG STRUT O/B TRIPOD

15. DISPATCH STATION	16. PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
69	265	FINISH HONE LUG (B) BUSHING I.D. 1.625/1.626 *C/P MOVE		001 MNPRA 002 03 003 DR03 005 X8433A2	
69	275	MACHINE LUG (C) BUSHING O.D. TO FIT HOLE *C/P MOVE P/N 68C29160-03		001 MNPRA 002 03 003 LE02	
69	280	LUG (C) BUSHING INSTALLATION. P/N 68C29160-03 PRESS FIT .0005/.0015 FINISH HONE BUSHING I.D. 2.000/2.001 NOTE: BUSHING WALL THICKNESS MUST		001 MNPRA 002 03 003 BE01	
		NOT BE LESS THAN .030 RECORD WEAR DIM IF REWORK LIMITS ARE			
		EXCEEDED..... RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS..... *C/P MOVE			
69	285	FINISH HONE LUG (C) BUSHING I.D. 2.000/2.001 *C/P MOVE		001 MNPRA 002 03 003 DR03 005 X8433A2	
69	295	MACHINE LUG (D) BUSHING O.D. TO FIT HOLE *C/P MOVE P/N 68C29160-05		001 MNPRA 002 03 003 LE02	
69	300	LUG (D) BUSHING INSTALLATION. PRESS FIT .0005/.0015 NOTE: BUSHING WALL THICKNESS MUST NOT BE LESS THAN .030		001 MNPRA 002 03 003 BE01	
		RECORD WEAR DIM IF REWORK LIMITS ARE (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16006N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1988—548-143

16006N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89044 PAGE 2 OF 2 PAGES

2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	LINK, DRAG STRUT O/B TRIPOD

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18 MECHANIC	19. "P"	20. "Q"
		EXCEEDED_____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS_____ *C/P MOVE			
69 /	305	FINISH HONE LUG (B) BUSHING I.D. 1.250/1.251 *C/P MOVE		001 MNPRA 002 03 003 DR03 005 X863362	
69 /	310	MACHINE LUG (A) BUSHING O.D. TO FIT HOLE *C/P MOVE P/N 68C29160-27		001 MNPRA 002 03 003 LE02	
69 /	320	LUG (A) BUSHING INSTALLATION. MAKE FROM 4130 180,000 PSI. PRESS FIT .0005/.0015 LENGTH .495/.497 OR USE BUSHING		001 MNPRA 002 03 003 BE01	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED			
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS_____ *C/P MOVE			
69 /	325	FINISH HONE LUG (A) BUSHING I.D. 1.250/1.251 *C/P MOVE		001 MNPRA 002 03 003 DR03 005 X863362	
[redacted]	350 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 95B		001 MNPGP 002 06 003 FA08	
[redacted]	360 *REQD*	FINAL PRODUCT VISUAL INSPECTION * C/P MOVE		001 MNPGP 002 06 003 FA08	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16006N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1988—548-104

16007N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89046 | PAGE 1 OF ___ PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
		MNPGP		

7 PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.
	1. 4S-1-182 2. 4S1-57-3	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
B-52 MA1N		

13. SERIAL NUMBER	14 NOUN	
	LINK, DRAG STRUT I/B TRIPOD	17142A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 5-35964-3		NSN 1620000922837 C/N 17142A 17143A 3445AA			
		******** UNIT COST: $187.00 ******** GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 FMPI IAW MIL-STD-1949			
		P/O NO1561 CAD PLATE IAW MIL-STD-870 BLAST IAW MIL-STD-1504 BAKE IAW 4S-1-182			
		MAOI 74-12 IVD ALUM PLATE IAW MIL-C-83488A ALODINE IAW MIL-C-5541			
		**** ****STEEL 200,000/220,000******** ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THE DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16007N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1986—646-104

16007N **WORK CONTROL DOCUMENT (MEDS)** 1 DATE 89046 ACT

2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN	
	LINK, DRAG STRUT I/B	TRIPOD

15. DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		STATIONS. WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIRMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	5-35963-3			
	REQD	DISASSEMBLE *C/P MOVE NOTE: REMOVE ALL BUSHINGS.		001 MNPGW 002 02 003 MD03 005 X874523	
				006 X874525	
	REQD	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 SL01	
	REQD	BLAST CLEAN ONLY *C/P MOVE		001 MNPGW 002 03 003 BL01	
		BAKE 4 HRS AT 350-400F DATE IN_____TIME IN_____ (CONTINUED)		001 MNPGW 002 03 003 BK03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16007N
		B	D	

AFLC FORM 055 NOV. 80 PREVIOUS EDITION WILL BE USED

☆ U.S. GOVERNMENT PRINTING OFFICE: 1985—648-143

16007N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89046 | PAGE 3 OF ___ PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	LINK, DRAG STRUT I/B TRIPOD

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]		*C/P MOVE	M	001 MNPNA 002 05 003 MS03	
[redacted]	*REQD*	E AND I INSPECTION LUG (E) I.D. 1.312/1.313 WEAR 1.314		001 MNPGW 002 04 003 EI01	
		LUG (F) I.D. 1.250/1.251 WEAR 1.252 ********** N O T E ********** * A MINIMUM OF AT LEAST TWO FMPI'S * * IS REQUIRED. * ********** *C/P MOVE			
69	070	REMOVE BUSHINGS STA 34 CAN NOT REMOVE *C/P MOVE		001 MNPRA 002 03 003 BE01	
26	075	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	080	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	090	STRIP ~~RUTS~~ Rust *C/P MOVE		001 MNPRC 002 02 003 CS02	
69	100	[redacted] (E) OVERSIZE TO CLEANUP MAX 1.372/1.393 *C/P MOVE		001 MNPRA 002 03 003 MH06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16007N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1988—548-163

16007N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89046 | PAGE 4 OF ___ PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	LINK, DRAG STRUT I/B TRIPOD

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	120	MACHINE LUG (F) OVERSIZE TO CLEANUP MAX I.D. 1.310/1.350 *C/P MOVE		001 MNPRA 002 03 003 MH06	
26	130	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	135	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	140	CAD PLATE TYPE II CLASS I 1.2 SQ FT AT 60-84 AMPS TIME OUT_____DATE OUT_____ *C/P MOVE		001 MNPRC 002 03 003 CA01	
26B	160	BAKE 23 HRS AT 350-400F WITHIN 4 HRS OF CAD DATE IN TIME IN		001 MNPRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
26	200	IRIDITE *C/P MOVE		001 MNPRC 002 02 003 IR01	
	.65	*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	mi	001 MNPNA 002 06 003 ML04	
26	213	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION--160 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK (CONTINUED)		001 MNPRC 002 03 003 IV01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16007N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1969—349-165

16007N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89046 | PAGE 5 OF __ PAGES

2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6 DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	LINK, DRAG STRUT I/B TRIPOD

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		IS DONE, BEFORE USING IVD OPTION. *C/P MOVE			
26	217	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNPRC 002 03 003 TA01	
69	218	MACHINE LUG (E) BUSHING *C/P MOVE P/N 68C29160-09		001 MNPRA 002 03 003 LE02	
69	219	INSTALL LUG (E) BUSHING *C/P MOVE		001 MNPRA 002 03 003 BE01	
69	220	LUG (E) BUSHING REAM P/N 68C29160-09 PRESS FIT .0005/.0015 FINISH LINE BORE OR HONE I.D. 1.312/1.313		001 MNPRA 002 03 003 HH00	
		NOTE: BUSHING WALL THICKNESS MUST NOT BE LESS THAN .030 RECORD WEAR DIM IF REWORK LIMITS ARE			
		EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE			
69	238	MACHNINE LUG (F) BUSHING *C/P MOVE P/N 68C29160-11		001 MNPRA 002 03 003 LE02	
69	239	INSTALL LUG (F) BUSHING *C/P MOVE		001 MNPRA 002 03 003 BE01	
69	240	LUG (F) BUSHING REAM P/N 68C29160-11 PRESS FIT .0005/.0015 FINISH LINE BORE OR HONE I.D. (CONTINUED)		001 MNPRA 002 03 003 HH00	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16007N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1989—648-163

16007N **WORK CONTROL DOCUMENT (MEDS)** | 1. DATE [redacted] | PAGE ___ OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	LINK, DRAG STRUT I/B TRIPOD

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		1.250/1.251 NOTE: BUSHING WALL THICKNESS MUST NOT BE LESS THAN .630 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED_____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS_____ *C/P MOVE			
[redacted]	270 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 95B		001 MNPGP 002 06 003 FA08	
[redacted]	280 *REQD*	FINAL PRODUCT VISUAL INSPECTION * C/P MOVE		001 MNPGP 002 06 003 FA08	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16007N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1989—648-163

16008N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 8904 [redacted]

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.
	1. 4S-1-182 2. 4S1-57-3	

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
B-52 MAIN		

13. SERIAL NUMBER	14 NOUN
	STEERING PLATES ASSY

17142A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 5-68457-5		NSN 1620006052768 C/N 17142A 17143A 69855A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		BAKE IAW 4S-1-182 MAOI 74-12			
		FMPI IAW MIL-STD-1949 P/O N01561			
		FLASH CHROME PLT IAW MIL-STD-1501 P/O N41321			
		DRY FILM LUBE IAW MIL-L-46010 MIL-L-46147			
		CAD PLATE IAW MIL-STD-870			
		BRUSH PLATE IAW MIL-STD-865 4S-1-182			
		STRIP CHROME IAW MIL-STD-866			
		IVD ALUM PLATE IAW MIL-C-83488A			
		ALODINE IAW MIL-C-5541			
		BLAST IAW MIL-STD-1504			
		*****UNIT COST $2500.00*****			
		****STEEL 4340 180,000/240,000****			
		ALL PERSONNEL INVOLVED IN THE WORK			
		PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN			
		THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLI-			
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16008N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1988—549-163

16008N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89046 | PAGE 2 OF PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 'OPTIONAL

13. SERIAL NUMBER	14 NOUN
	STEERING PLATES ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		CABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY			
		CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS			
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	5-68457-5			
[redacted]	*REQD*	DISASSEMBLE *C/P MOVE NOTE: REMOVE ALL BUSHINGS.		001 MNPGW 002 02 003 MD03 005 X8745250 006 X8745234	
[redacted]	*REQD*	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 SL01	
[redacted]	*REQD*	BLAST CLEAN ONLY *C/P MOVE		001 MNPGW 002 03 003 BL01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16008N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1988—548-124

16008N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89046 | PAGE 3 OF __ PAGES

2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODE..DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	STEERING PLATES ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		BAKE 4 HRS AT 350-400F		001 MNPGW	
				002 03	
	REQD	DATE IN_____TIME IN_____		003 BK03	
		DATE OUT_____TIME OUT_____			
		*C/P MOVE			
[redacted]		*C/P MOVE		001 MNPNA	
			M	002 05	
	REQD			003 ML04	
[redacted]		E AND I INSPECTION		001 MNPGW	
				002 04	
	REQD	BEARING AREA I.D. 11.273/11.282		003 EI01	
		WIDTH OF BEARING ON (91)			
		1.488/1.4906			
		WIDTH OF BEARING ON (90)			
		1.480/1.4861			
		MOUNTING BOLT HOLES .875/.876/.877			
		STEERING LUGS 3.9988/3.9998/4.0008			
		4.0008 TO 4.004 BRUSH NICKEL PLATE			
		TORQUE ARM LUGS 1.751/1.752			
		WEAR 1.753			
		*C/P MOVE			
26	070	VAPOR DEGREASE *C/P MOVE		001 MNPRC	
[redacted]				002 03	
				003 DG01	
26	080	STRIP CAD *C/P MOVE		001 MNPRC	
[redacted]				002 02	
				003 CS01	
26	090	STRIP RUST *C/P MOVE		001 MNPRC	
[redacted]				002 02	
				003 CS02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16008N
		B	D	

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☆ U.S. GOVERNMENT PRINTING OFFICE: 1988—548-163

16008N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89046 PAGE __ OF __ PAGES

2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	STEERING PLATES ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	100	STRIP CHROME FROM BEARING AREA *C/P MOVE		001 MNPRC 002 02 003 SC02	
69	120	DRILL TWO HOLES IN BOTTOM PLATE IF NOT PREVIOUSLY DONE IAW FIG 2-21 *C/P MOVE		001 MNPRA 002 03 003 MV00	
69	140	MOUNTING BOLT HOLES OVERSIZE REPAIR USE SHOP SPECIAL STEERING PLATE FIXTURE REAM TO CLEANUP .939/.957 250 RMS *C/P MOVE		001 MNPRA 002 03 003 DR03 005 X8633628	
69	160	TORQUE ARM LUG HOLES OVERSIZE REPAIR REAM OVERSIZE TO CLEANUP 1.813/1.831 250 RMS *C/P MOVE		001 MNPRA 002 03 003 DR03 005 X8633629	
69	180	NICK AND BURR AND REMOVE PITTING IAW PARA 2-44 & (NOTE) *C/P MOVE		001 MNPRA 002 03 003 BE01	
[redacted]		WORKED AREAS DATE OUT_____TIME OUT_____ *C/P MOVE	M	001 MNPNA 002 06 003 TE03	
		* * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *			
26B	190	BAKE 4HRS AT 350-400F WITHIN 8HRS OF ETCH DATE IN_____TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * * (CONTINUED)	M	001 MNPNA 002 06 003 ML04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16008N
		B	D	

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16008N **WORK CONTROL DOCUMENT (MEDS)**

1. DATE	PAGE ___ OF ___ PAGES
89046	

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	STEERING PLATES ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *			
26	220	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	230	PREPARE FOR CHROM PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	235	PREPARE FOR FLASH CHROME PLATE OF CHROME PLATED BEARING SURFACES, MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED		001 MNPRC 002 02 003 BE01	
26	240	FLASH CHROME PLATE CLASS III PLATING THICKNESS .0005/.0007 CHROME PLATED BEARING SURFACES TIME OUT DATE OUT		001 MNPRC 002 02 003 CP02 008 CD010	
		MECHANIC SIGN OFF REQUIRED----------> *C/P MOVE			
26B	250	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME DATE IN_____ TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____ TIME OUT_____ *C/P MOVE			
26	255	GRIT BLAST ALL AREAS TO BE CAD PLATED/IVD ALUM PLATED "N O T E" GRIT 3.999 STEERING ACTUATOR HOLES		001 MNPRC 002 01 003 BL02	
		O.D. IF CORROSION FORMS A CIRCULAR PATTERN *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16008N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1988—548-163

16008N **WORK CONTROL DOCUMENT (MEDS)** | 1. DATE 890[redacted] | PAGE [redacted]

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	STEERING PLATES ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	260	CAD PLATE TYPE II CLASS I 6.2 SQ FT AT 310-434 AMPS TIME OUT_____DATE OUT_____ *C/P MOVE		001 MNPRC 002 03 003 CAD1	
26B	280	BAKE 24 HRS AT 350-400F WITHIN 4 HRS OF CAD PLATING DATE IN TIME IN		001 MNPRC 002 02 003 BKD1	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]	165	*C/P MOVE * * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *	M	001 MNPNA 002 06 003 MLD4	
26	302	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DGD1	
26	303	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 280 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE		001 MNPRC 002 03 003 IVD1	
26BP	305	BRUSH PLATE STEERING LUGS USING HIGH SPEED NICKEL TO MAINTAIN FINISH I.D. OF 3.9988/3.9998 *C/P MOVE		001 MNPRC 002 02 003 BPD1	
26	320	DRY FILM LUBE CHROME PLATED AREAS IAW MIL-L-46010 OR MIL-L-46147 **********N O T E********** (CONTINUED)		001 MNPRC 002 03 003 ELD1	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16008N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1989—649-143

16008N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89046 | PAGE 7 OF PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	STEERING PLATES ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
		DO NOT DRY FILM LUBE STEERING LUGS IF LUGS HAVE BEEN BRUSH PLATED WITH HIGH SPEED NICKEL. *C/P MOVE			
26B	340	BAKE IAW MANUFACTURES FILM LUBE SPECIFICATION 1 HR AT 400 DEG DATE IN TIME IN		001 MNPRC 002 02 003 BK02	
		DATE OUT TIME OUT *C/P MOVE			
26	360	IRIDITE *C/P MOVE		001 MNPRC 002 02 003 IR01	
26	370	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNPRC 002 03 003 TA01	
69	398	MACHINE MOUNTING BOLT HOLE BUSHING *C/P MOVE P/N 68C29160-21 P/N 68C29160-23		001 MNPRA 002 03 003 LE02	
69	400	MOUNTING BOLT HOLE BUSHING INSTALLATION P/N 68C29160-23 OR -21 PRESS FIT .0005/.015 KEEP MATCHED AFTER REWORK 250 RMS *C/P MOVE		001 MNPRA 002 03 003 BE01	
69	[illegible]	[illegible] HOLE BUSHING [illegible] *C/P MOVE		001 MNPRA 002 03 003 DR03 005 X8633628	
69	[illegible]	[illegible] BUSHING *C/P MOVE P/N 68C29160-25		001 MNPRA 002 03 003 LE02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16008N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1989—640-165

16008N **WORK CONTROL DOCUMENT (MEDS)** | 1. DATE 89046 | PAGE 8 OF 8 PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	STEERING PLATES ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	420	TORQUE ARM LUG BUSHING INSTALLATION P/N 88C29160-25 PRESS FIT .001/.002 250 RMS		001 MNPRA 002 03 003 BE01	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED_____ RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS			
		*C/P MOVE			
69	425	TORQUE ARM LUG BUSHING FINISH I.D. 1.751/1.752 *C/P MOVE		001 MNPRA 002 03 003 DR03 005 X8633629	
[redacted]	430 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 06 003 FA08	
[redacted]	440 *REQD*	FINAL PRODUCT VISUAL INSPECTION * C/P MOVE		001 MNPGP 002 06 003 FA08	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16008N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1988—549-555

16009N **WORK CONTROL DOCUMENT (MEDS)** | 1. DATE 89048 | PAGE__OF__PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4S-1-182 4S1-57-3	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
B-52 MAIN		

13. SERIAL NUMBER	14. NOUN
	LINK ASSY TORSION

17142A

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 1-80721-1		NSN C/N 1620003170530 17142A 17143A			
		****** UNIT COST: $152.14 ******** GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 FMPI IAW MIL-STD-1949			
		P/O N01561 CAD PLATE IAW MIL-STD-870 BAKE IAW 4S-1-182 MAOI 74-12			
		IVD ALUM PLATE IAW MIL-C-83488A ALODINE IAW MIL-C-5541 BLAST IAW MIL-STD-1504 *****STEEL 180,000/200,000 PSI******			
		ALL PERSONNEL INVLOVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE			
		FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE			
		APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY			
		CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16009N
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☆ U.S. GOVERNMENT PRINTING OFFICE: 1988—548-163

16009N WORK CONTROL DOCUMENT (MEDS)

PAGE 2 OF 2 PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	LINK ASSY TORSION

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO			
		PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	1-80721-1			
	REQD	DISASSEMBLE *C/P MOVE NOTE: REMOVE ALL BUSHINGS.		001 MNPGW 002 02 003 MD03 005 X8745234	
				006 X8745250	
	REQD	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 SL01	
	REQD	BLAST CLEAN ONLY *C/P MOVE		001 MNPGW 002 03 003 BL01	
	REQD	BAKE 4 HRS AT 350-400F DATE IN_____TIME IN_____		001 MNPGW 002 03 003 BK03	
		DATE OUT_____TIME OUT_____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16009N
		B	D	

★ U.S. GOVERNMENT PRINTING OFFICE: 1969—669-163

16009N **WORK CONTROL DOCUMENT (MEDS)**

1. DATE 82046 — PAGE 3 OF PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	LINK ASSY TORSION

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	*REQD*	*C/P MOVE	M	001 MNPNA 002 05 003 ML04	
[redacted]	*REQD*	E & I INSPECTIONS APEX BUSHING I.D. 1.250/1.2515		001 MNPGW 002 04 003 EI01	
		BASE BOSS HOLE I.D. 2.120/2.1205 ********** N O T E ********** * A MINIMUM OF AT LEAST TWO FMPI'S * * IS REQUIRED. * ********** *C/P MOVE			
26 [redacted]	085	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26 [redacted]	090	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26 [redacted]	093	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
26 [redacted]	095	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		001 MNPRC 002 01 003 BL02	
26 [redacted]	100	CAD PLATE TYPE II CLASS I .9 SQ FT AT 45-63 AMPS TIME OUT_____DATE OUT_____ *C/P MOVE		001 MNPRC 002 03 003 CA01	
26B [redacted]	120	BAKE 23 HRS AT 350-400F WITHIN 4 HRS OF CAD DATE IN_____TIME IN_____ (CONTINUED)		001 MNPRC 002 02 003 BK01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16009N
		B	D	

AFLC FORM 350 NOV. 80

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2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	LINK ASSY TORSION

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DATE OUT_____TIME OUT_____ *C/P MOVE			
26	140	IRIDITE *C/P MOVE		001 MNPRC 002 02 003 IR01	
[redacted]	.65	*C/P MOVE * * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *	M	001 MNPNA 002 06 003 ML04	
26	160	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 120 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE		001 MNPRC 002 03 003 IV01	
26	170	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNPRC 002 03 003 TA01	
69	178	MACHINE APEX BOSS BUSHING I.D. 1.250/1.251 *C/P MOVE P/N 4-80724-1		001 MNPRA 002 03 003 LE02	
69	180	APEX BOSS BUSHING INSTALLATION BASE METAL 1.499/1.500 BUSHING 4-80724-1 DRILL GREASE HOLE AND FINISH HONE BUSHING I.D. 1.250/1.251 125 RMS *C/P MOVE		001 MNPRA 002 03 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16009N
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★ U.S. GOVERNMENT PRINTING OFFICE: 1988—549-165

16009N WORK CONTROL DOCUMENT (MEDS)

DATE [redacted] 89 | PAGE [redacted] OF [redacted]

2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 'OPTIONAL

13. SERIAL NUMBER	14 NOUN
	LINK ASSY TORSION

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	200 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 95[redacted]		001 MNPGP 002 06 003 FA08	
[redacted]	210 *REQD*	FINAL PRODUCT VISUAL INSPECTION * C/P MOVE		001 MNPGP 002 06 003 FA08	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16009N
		B	D	

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☆ U.S. GOVERNMENT PRINTING OFFICE: 1980—340-163

16017N

WORK CONTROL DOCUMENT (MEDS)

1. DATE [redacted] 89044 PAGE __ OF __ PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4S1-1-182	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
B 52M	4S1-5	

13. SERIAL NUMBER	14. NOUN
	JACKSHAFT ASSY

17142A

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 5-68470-2		NSN 1620003079442 C/N 17142A 17143A 28.51M			
		GOVERNING SPECIFICATIONS: AFLCR 66-5, MANDI 66-3			
		FMPI IAW MIL-STD-1949 P/O NC1561			
		FPI IAW MIL-STD-6866 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT			
		HAVE BEEN THOROUGHLY TRAINED & ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES HAZARDS CONTAINED IN THE BASIC [illegible] OTHER [illegible]			
		[illegible] APPLICABLE TO & UTILIZED IN CONJUNCTION WITH THIS [illegible]			
		COMPLETE [illegible] & PROPER [illegible] TIONS/DISPATCH STATIONS (*C/P MUST)			
		********** W A R N I N G **********			
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRING THE USE OF EQUIPMENT/ PROCESSES/CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA			

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16017N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1988—548-166

16017N **WORK CONTROL DOCUMENT (MEDS)** [redacted] 89046 PAGE 2 OF [redacted] PAGES

2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	**14 NOUN**	
	JACKSHAFT ASSY	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		STAMP.			
	001	5-88#70-2			
[redacted]	*REQD*	BLAST CLEAN *C/P MOVE		001 MNFGW 002 03 003 BL01	
[redacted]	*REQD*	DISASSEMBLE *C/P MOVE		001 MNFGW 002 06 003 FA08	
[redacted]	*REQD*	DEGREASE, (HAND WASH) *C/P MOVE		001 MNFGP 002 06 003 FA08	
[redacted]	*REQD*	*C/P MOVE	M	001 MNFNA 002 05 003 ZY05	
[redacted]	*REQD*	*C/P MOVE	M	001 MNFNA 002 05 003 MG03	
[redacted]	*REQD*	*C/P MOVE		001 MNFNA 002 05 003 DG01	
[redacted]	050 *REQD*	ASSEMBLE *C/P MOVE		001 MNFGP 002 06 003 FA08	
[redacted]	055 *REQD*	ALIGN USING EXISTING FIXTURING AND FREE PLAY CHECK *C/P MOVE		001 MNFGP 002 06 003 FA08	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16017N
		B	D	

★ U.S. GOVERNMENT PRINTING OFFICE: 1989—649-183

16017N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89046 | PAGE 2 OF ___ PAGES

2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14. NOUN
	JACKSHAFT ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	070 *RC004	PAINT: MASK PRIME PAINT *C/P MOVE		001 MNPGP 002 09 003 WB03	
[redacted]	080 *RC004	FIN.. ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL ENTRIES IN ALL BLOCKS THIS F/S		001 MNPGP 002 09 003 WB03	
[redacted]	090 *RC004	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 09 003 WB03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	16017N
		B	D	

AFLC FORM 228 NOV 80

★ U.S. GOVERNMENT PRINTING OFFICE: 1988—548-163

B-52 MLG

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 09/06/89 A-E046B-MM1-DY-M45 PAGE 0

'RUT B-52 MLG RCC MMPRA 4S1-57-3

T K D L	R A K C	F PF A/R REV FA DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PC
E	JA	EA 1	J 85204	.59	PERCENT ENGR 95.6	MACH REP OUTER CYL B52 507	16.27		9.60	
	JA	01 00		.00		PART NUMBER/NSN	.000	.000	.000	
					7027516-10	162000241544				
	JA	01 15		.05		O/B TRUNNION C/BORE REWORK	1.062	.008	.061	
E			RML-SU-V3	.33	S/U VERT MIL BORE FXTR HOIST	PRORATE OP 060,080 & 100	1.03687		.393	
E			RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
E			RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137	
E			RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP		.05541		.063	
E			RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
E			RML-BA-CH	1.00	BORE HOLE 2 X 6 GROUP 1		.30098		.346	
E			RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
	JA	01 15		.05		I/B TRUNNION C/BORE REWORK	1.062	.008	.061	
E			RML-SU-V3	.33	S/U VERT MIL BORE FXTR HOIST	PRORATE OP 060,080 & 100	1.03687		.393	
E			RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
E			RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137	
E			RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP		.05541		.063	
E			RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
E			RML-BA-CH	1.00	BORE HOLE 2 X 6 GROUP 1		.30098		.346	
E			RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
	JA	01 15		.05		MACH NEW KEYWAYS	1.491	.011	.086	
					H					
E			RML-SU-V3	.33	S/U VERT MIL BORE FXTR HOIST	PROATED OVER 060.070&080	1.03687		.393	
E			RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
E			RML-AL-AC	2.00	ALIGN HOLE TO SPINDLE ROD	2 EA. KEYWAYS	.07609		.175	
E			RML-AL-BB	2.00	ALIGN VERTICAL AXIS CLAMP	2 EA KEYWAYS	.11975		.275	
E			RML-AL-BA	2.00	ALIGN HORIZ AXIS CLAMP	2 EA KEYWAYS	.05541		.127	
E			RML-BA-AH	2.00	BORE HOLE 1 X 6 GROUP 1	2 EA KEYWAYS	.23942		.550	
E			RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
	JA	01 15		.15		BEP DAMAGED CAM KEYWAYS	1.778	.040	.307	
E			RML-SU-V3	.33	S/U VERT MIL BORE FXTR HOIST	PRORATE OP 060,080 & 100	1.03687		.393	
E			RML-HP-CC	.10	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.018	
E			RML-AL-AC	2.00	ALIGN HOLE TO SPINDLE ROD	2 EA. KEYWAYS	.07609		.175	
E			RML-AL-BB	2.00	ALIGN VERTICAL AXIS CLAMP	2 EA KEYWAYS	.11975		.275	
E			RML-AL-BA	2.00	ALIGN HORIZ AXIS CLAMP	2 EA KEYWAYS	.05541		.127	
E			RML-BA-BH	2.00	BORE HOLE 1.5 X 6 GROUP 1	2 EA KEYWAYS	.27020		.621	
E				2.00		BURNISH REMOVED KEYWAYS 2EA	.10800		.248	
E			RLA-FF-A6	5.00	FACE FINISH (1/2 DIA GRP 4 5	BUSHINGS	.03033		.174	
E			RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
	JA	01 15		.08		O/B TRUNNION REPAIR	1.191	.014	.110	
E			RML-SU-V3	.25	S/U VERT MIL BORE FXTR HOIST	PRORATE OP 450,460,480 & 500	1.03687		.298	
E			RML-AL-BB	2.00	ALIGN VERTICAL AXIS CLAMP	2 EA HOLES HYD LINES	.11975		.275	
E			RML-AL-BA	2.00	ALIGN HORIZ AXIS CLAMP	2 EA HOLES HYD LINES	.05541		.127	
E			RML-AL-AC	2.00	ALIGN HOLE TO SPINDLE ROD	2 EA HOLES HYD LINES	.07609		.175	
E			RML-BA-AF	2.00	BORE HOLE 1 X 3 GROUP 1	2 EA HOLES HYD LINES	.20666		.475	
E			RLG-HP-V1	1.00		ROTATE FIXTURE TO NEXT HOLE	.00612		.007	
E			RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
				'5	.05		I/B TRUNNION REPAIR	1.191	.009	.068
E			RML-SU-V3	.25	S/U VERT MIL BORE FXTR HOIST	PRORATE OP 450,460,480 & 500	1.03687		.298	
E			RML-AL-BB	2.00	ALIGN VERTICAL AXIS CLAMP	2 EA HOLES HYD LINES	.11975		.275	

0030	E		RML-AL-BA	2.00	ALIGN HORIZ AXIS CLAMP	2 EA HOLES HYD LINES	.05541		.127
0035	E		RML-AL-AC	2.00	ALIGN HOLE TO SPINDLE ROD	2 EA HOLES HYD LINES	.07609		.175
0	E		RML-BA-AF	2.00	BORE HOLE 1 X 3 GROUP 1	2 EA HOLES HYD LINES	.20666		.475
45	E		RLG-HP-V1	1.00		ROTATE FIXTURE TO NEXT HOLE	.00612		.007
0050	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0120		JA 01	15	.05		OBORD TRUNNION RADIUS REP	1.066	.008	.061
0010	E		RML-SU-V3	.25	S/U VERT MIL BORE FXTR HOIST	PRORATE OP 450,460,480 & 500	1.03687		.298
0020	E		RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137
0030	E		RML-AL-BA	2.00	ALIGN HORIZ AXIS CLAMP	2 EA SIDES RADIUS	.05541		.127
0035	E		RML-AL-AC	2.00	ALIGN HOLE TO SPINDLE ROD	2 EA SIDES TO TRUNION	.07609		.175
0040	E		RML-BA-HA	2.00	BORE HOLE 4.5 X 1/2 GROUP 1	2 EA SIDES RADIUS PER TRUN	.20242		.465
0042	E		GID-SA-A1	1.00	STAMP WITH METAL STAMP	STAMP LETTER "T"	.00342		.003
0045	E		RLG-HP-V1	1.00		ROTATE FIXTURE TO NEXT HOLE	.00612		.007
0050	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0130		JA 01	15	.05		I/B TRUNNION RADIUS REP	1.056	.008	.061
0010	E		RML-SU-V3	.25	S/U VERT MIL BORE FXTR HOIST	PRORATE OP 450,460,480 & 500	1.03687		.298
0020	E		RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137
0030	E		RML-AL-BA	2.00	ALIGN HORIZ AXIS CLAMP	2 EA SIDES TO TRUNION	.05541		.127
0035	E		RML-AL-AC	2.00	ALIGN HOLE TO SPINDLE ROD	2 EA SIDES TO TRUNION	.07609		.175
0040	E		RML-BA-HA	2.00	BORE HOLE 4.5 X 1/2 GROUP 1	2 EA RADIUS PER TRUNION	.20242		.465
0050	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0240		JA 01	15	.22		ORFICE TUBE REPAIR	.971	.032	.246
0010	E		RML-SU-V3	.33	S/U VERT MIL BORE FXTR HOIST	PRORATE OP 240,260&280	1.03687		.393
0015	E		RML-HP-CC	.33	HOIST HANDLE NO WRAP 2 CLAMP	PRORATE OP 240,260&280	.15776		.059
0020	E		RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137
0030	E		RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP		.05541		.063
0035	E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087
0040	E		RML-BA-BC	1.00	BORE HOLE 1.5 X 1.5 GROUP 1		.19798		.227
5	E		KAL-SM-31	1.00	SPOT-FACE OR COUNTERBORE	SPOTFACE	.02004		.023
.46	E		RLA-RC-BA	1.00	RECESS /02 - 1 DIA 1/8 DP G1	CUT RADIUS	.04181		.048
0050	E		RPL-MA-B1	.00		ROLBURNISH	.00335		.057
0055	E		RLG-HP-V1	.00		ROTATE FIXTURE TO NEXTHOLE	.00612		.007
0060	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0260		JA 01	15	.50		O/S MACH O/B TRIPOD LUGS	.933	.070	.537
0010	E		RML-SU-V3	.33	S/U VERT MIL BORE FXTR HOIST	PRORATE OP 240,260&280	1.03687		.393
0015	E		RML-HP-CC	.33	HOIST HANDLE NO WRAP 2 CLAMP	PRORATE OP 240,260&280	.15776		.059
0020	E		RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137
0030	E		RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP		.05541		.063
0035	E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087
0040	E		RML-BA-BF	1.00	BORE HOLE 1.5 X 3 GROUP 1		.22205		.255
0050	E		RPL-MA-B1	15.00		ROLBURNISH	.00335		.057
0055	E		RLG-HP-V1	1.00		ROTATE FIXTURE TO NEXT HOLE	.00612		.007
0060	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0280		JA 01	15	.36		O/S MACH I/B TRIPOD LUGS	.919	.050	.381
0010	E		RML-SU-V3	.33	S/U VERT MIL BORE FXTR HOIST	PRORATE OP 240,260&280	1.03687		.393
0015	E		RML-HP-CC	.33	HOIST HANDLE NO WRAP 2 CLAMP	PRORATE OP 240,260&280	.15776		.059
0020	E		RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137
0030	E		RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP		.05541		.063
0035	E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087
0040	E		RML-BA-BE	1.00	BORE HOLE 1.5 X 2.5 GROUP 1		.21403		.246
0050	E		RPL-MA-B1	15.00		ROLBURNISH	.00335		.057
0060	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0300		JA 01	15	.43		O/S LOWER TRIPOD LUGS	.821	.053	.406
010	E		RML-SU-V3	.17	S/U VERT MIL BORE FXTR HOIST	PRORATE OP 300,320,340,360,	1.03687		.202
1					380 & 400				
015	E		RML-HP-CC	.17	HOIST HANDLE NO WRAP 2 CLAMP	OP 300,320,340,360,380 & 400	.15776		.030

0	E		RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP			.11975	.137
	E		RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP			.05541	.063
5	E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD			.07609	.087
0040	E		RML-BA-CM	1.00	BORE HOLE 2 X 6 GROUP 1			.30098	.346
0050	E		RPL-MA-B1	15.00		ROLBURNISH		.00335	.057
0055	E		RLG-HP-V1	1.00		ROTATE FIXTURE TO NEXT HOLE		.00612	.007
0060	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001	.011
0320		JA 01	15	.15		O/S STEERING LUG I/B		.758 .017	.131
0010	E		RML-SU-V3	.17	S/U VERT MIL BORE FXTR HOISTOP 300,320,340,360,380 & 400			1.03687	.202
0015	E		RML-HP-CC	.17	HOIST HANDLE NO WRAP 2 CLAMPOP 300,320,340,360,380 & 400			.15776	.030
0020	E		RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP			.11975	.137
0030	E		RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP			.05541	.063
0035	E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD			.07609	.087
0040	E		RML-BA-CF	1.00	BORE HOLE 2 X 3 GROUP 1			.23744	.273
0050	E		RPL-MA-B1	15.00		ROLBURNISH		.00335	.057
0055	E		RLG-HP-V1	1.00		ROTATE FIXTURE TO NEXT HOLE		.00612	.007
0060	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001	.011
0340		JA 01	15	.22		O/S STEERING LUG O/B		.758 .025	.192
0010	E		RML-SU-V3	.17	S/U VERT MIL BORE FXTR HOISTOP 300,320,340,360,380 & 400			1.03687	.202
0015	E		RML-HP-CC	.17	HOIST HANDLE NO WRAP 2 CLAMPOP 300,320,340,360,380 & 400			.15776	.030
0020	E		RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP			.11975	.137
0030	E		RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP			.05541	.063
0035	E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD			.07609	.087
0040	E		RML-BA-CF	1.00	BORE HOLE 2 X 3 GROUP 1			.23744	.273
0050	E		RPL-MA-B1	15.00		ROLBURNISH		.00335	.057
0055	E		RLG-HP-V1	1.00		ROTATE FIXTURE TO NEXT HOLE		.00612	.007
0060	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001	.011
		JA 01	15	.05		STEERING LUG COUNTER BORE		1.095 .008	.063
0	E		RML-SU-V3	.17	S/U VERT MIL BORE FXTR HOISTOP 300,320,340,360,380 & 400			1.03687	.202
0015	E		RML-HP-CC	.17	HOIST HANDLE NO WRAP 2 CLAMPOP 300,320,340,360,380 & 400			.15776	.030
0020	E		RML-AL-BB	2.00	ALIGN VERTICAL AXIS CLAMP	2 EA LUGS IB & OB		.11975	.275
0030	E		RML-AL-BA	2.00	ALIGN HORIZ AXIS CLAMP	2 EA LUGS IB & OB		.05541	.127
0035	E		RML-AL-AC	2.00	ALIGN HOLE TO SPINDLE ROD	2 EA LUGS IB & OB		.07609	.175
0040	E		RML-BA-DA	2.00	BORE HOLE 2.5 X 1/2 GROUP 1	2 EA LUGS IB & OB		.18706	.430
0055	E		RLG-HP-V1	1.00		ROTATE FIXTURE TO NEXT HOLE		.00612	.007
0060	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001	.011
0380		JA 01	15	.05		O/S ACTUATOR LUG <SMALL>		.715 .005	.041
0010	E		RML-SU-V3	.17	S/U VERT MIL BORE FXTR HOISTOP 300,320,340,360,380 & 400			1.03687	.202
0015	E		RML-HP-CC	.17	HOIST HANDLE NO WRAP 2 CLAMPOP 300,320,340,360,380 & 400			.15776	.030
0020	E		RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP			.11975	.137
0030	E		RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP			.05541	.063
0035	E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD			.07609	.087
0040	E		RML-BA-CB	1.00	BORE HOLE 2 X 1 GROUP 1			.19508	.224
0050	E		RPL-MA-B1	15.00		ROLBURNISH		.00335	.057
0055	E		RLG-HP-V1	1.00		ROTATE FIXTURE TO NEXT HOLE		.00612	.007
0060	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001	.011
0400		JA 01	15	.05		O/S ACTUATOR LUG <LARGE>		.725 .005	.042
0010	E		RML-SU-V3	.17	S/U VERT MIL BORE FXTR HOISTOP 300,320,340,360,380 & 400			1.03687	.202
0015	E		RML-HP-CC	.17	HOIST HANDLE NO WRAP 2 CLAMPOP 300,320,340,360,380 & 400			.15776	.030
0020	E		RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP			.11975	.137
0030	E		RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP			.05541	.063
0035	E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD			.07609	.087
0	E		RML-BA-DC	1.00	BORE HOLE 2.5 X 1.5 GROUP 1			.21121	.242
0	E		RPL-MA-B1	15.00		ROLBURNISH		.00335	.057
0060	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001	.011
0420		JA 01	15	.08		ACTUATOR KEYSLOT REPAIR		2.147 .026	.198

0010	E		RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST		1.03487		1.192	
	E		RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
	E		RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137	
0030	E		RML-AL-BA	1.00	ALIGN HORIZ AXIS CLAMP		.05541		.063	
0035	E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0040	E		RML-BC-BA	1.00	BORE HOLE 1.5 X 1/2 GROUP 3		.24267		.279	
0050	E		RML-BA-AB	1.00	BORE HOLE 1 X 1 GROUP 1	BOLT HOLD	.18482		.212	
0060	E		GTL-TH-A1	1.00	TAP HOLE TO 0.25 IN THRD DIA		.01427		.016	
0070	N			1.00		MFG PLATE	.25000		.287	
0080	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0425		JA 01	15	.05		DOOR ACTUATOR LUG #146	.120	.001	.007	0
0010	E		RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATED HOLES 146,148,151	.27525		.079	
0020	E		RLA-DR-DA	1.00	DRILL HOLE 1/4-1/2 DIA (1/21/4		.03811		.043	
0030	E		RPL-MA-B1	1.00		ROLL BURNISH	.00335		.003	
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOCDOC		.01001		.011	
0430		JA 01	15	.08		DOOR ACTUATOR LUG REPAIR	.520	.006	.048	0
0010	E		RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE OP430,440,443,446	.27525		.079	
0020	E		RLA-DR-DA	5.00	DRILL HOLE 1/4-1/2 DIA (1/25 EA HOLES		.03811		.219	
0030	E		RPL-MA-B1	75.00		OCC ROLBURNISH 5 HOLES	.00335		.288	
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0440		JA 01	15	.05		2ND O/S DOOR ACT LUG REP	.520	.004	.030	0
0010	E		RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE OP430,440,443,446	.27525		.079	
0020	E		RLA-DR-DA	5.00	DRILL HOLE 1/4-1/2 DIA (1/25 EA HOLES		.03811		.219	
0030	E		RPL-MA-B1	75.00		OCC ROLBURNISH 5 HOLES	.00335		.288	
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0443		JA 01	15	.05		REAM HOLE #147 & ROLLBURNISH	.167	.001	.010	0
0010	E		RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE OP430,440,443,446	.27525		.079	
	E		RLA-DR-DA	1.00	DRILL HOLE 1/4-1/2 DIA (1/2		.03811		.043	
	E		RPL-MA-B1	15.00		ROLBURNISH	.00335		.057	
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0446		JA 01	15	.05		O/S HOLE #147 & ROLL BURNISH	.167	.001	.010	0
0010	E		RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE OP430,440,443,446	.27525		.079	
0020	E		RLA-DR-DA	1.00	DRILL HOLE 1/4-1/2 DIA (1/2		.03811		.043	
0030	E		RPL-MA-B1	15.00		ROLL BURNISH	.00335		.057	
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0460		JA 01	15	.05		REP LUG HOLE 148	.234	.002	.013	0
0010	E		RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATED 4 EA HOLES	.27525		.079	
0020	E		RLA-DR-DA	4.00	DRILL HOLE 1/4-1/2 DIA (1/2DRILL 4 EA HOLES		.03811		.175	
0030	E		RPL-MA-B1	1.00		ROLL BURNISH	.00335		.003	
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOCSIGN		.01001		.011	
0470		JA 01	15	.05		O/S HOLE 148	.244	.002	.014	0
0010	E		RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRPRATED 4 EA HOLES	.27525		.079	
0020	E		RLA-DR-DA	4.00	DRILL HOLE 1/4-1/2 DIA (1/24 EA HILES		.03811		.175	
0030	E		RPL-MA-B1	4.00		ROLBURNISH 4 EA HOLES	.00335		.015	
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOCSIGN		.01001		.011	
0480		JA 01	15	.05		REP LUG HOLE 151	.230	.002	.013	0
0010	E		RBW-SU-G1	.50	S/U FOR BENCH WORK GENERAL	2 EA HOLES	.27525		.158	
0020	E		RLA-DR-DA	2.00	DRILL HOLE 1/4-1/2 DIA (1/22 EA HOLES		.03811		.087	
0030	E		RPL-MA-B1	2.00		ROLBURNISH 2 EA HOLES	.00335		.007	
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOCSIGN		.01001		.011	
0490		JA 01	15	.05		O/S LUG HOLE 2 EA	.230	.002	.013	0
0010	E		RBW-SU-G1	.50	S/U FOR BENCH WORK GENERAL	O/S 2 EA HOLES # 151	.27525		.158	
0020	E		RLA-DR-DA	2.00	DRILL HOLE 1/4-1/2 DIA (1/20/S		.03811		.087	
	E		RPL-MA-B1	2.00		ROLLBURNISH 2 EA HOLES	.00335		.007	
	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOCSIGN		.01001		.011	
0500		JA 01	15	.05		REP LUG HOLE #150 4 EA	.244	.002	.014	0

0010	E		RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATED 4 EA HOLES	.27525		.079
0020	E		RLA-DR-DA	4.00	DRILL HOLE 1/4-1/2 DIA (1/24 EA HOLES		.03811		.175
0030	E		RPL-MA-B1	4.00		ROLL BURNISH 4 EA HOLES	.00335		.015
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	SIGN	.01001		.011
0502		JA 01	15	.05		REAM LIG HOLE 149 12 EA	.535	.004	.031
0010	E		RBW-SU-G1	.10	S/U FOR BENCH WORK GENERAL	PRORATED 12 EA HOLES	.27525		.031
0020	E		RLA-DR-DA	12.00	DRILL HOLE 1/4-1/2 DIA (1/2	DRILL 12 EA HOLES	.03811		.525
0030	E		RPL-MA-B1	12.00		ROLL BURNISH 12 EA HOLES	.00335		.046
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	SIGN	.01001		.011
0504		JA 01	15	.15		MACH UPPER STEERING JOURNAL	1.986	.045	.343
0010					FOR FLAME SPRAY				
0020	E		RML-SU-V3	.50		S/U LARGE LATHE W/FIXTURE	1.03687		.596
0025					PRORATE OP 0160 & 0140				
0030	E		RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK		.22097		.254
0040	E		KML-TA-JC	2.00	DIA 5.00-6.00 REM .033-.250	11 IN. O.D.	.09193		.211
0050	E		KML-TA-JD	2.00	DIA 6.0 REM .250 ADD INCH	11 IN. O.D.	.02665		.061
0060	N			1.00		LOCAL REWORK PITS IN FLANGE	1.00000		1.150
0070					AREA W/GRINDING MOTOR & FILE				
0080	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0506		JA 01	15	.15		MACH LOWER STEERING JOURNAL	1.322	.030	.228
0010					FOR FLAME SPRAY				
0020	E		RML-SU-V3	.50		S/U LARGE LATHE W/FIXTURE	1.03687		.596
0025					PRORATE OP 0160 & 0140				
0030	E		RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK		.22097		.254
0040	E		KML-TA-JC	2.00	DIA 5.00-6.00 REM .033-.250	11 IN. O.D.	.09193		.211
0050	E		KML-TA-JD	2.00	DIA 6.0 REM .250 ADD INCH	11 IN. O.D.	.02665		.061
0060	E		RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316
0070	E		RSG-JP-03	1.00	PREP HAND DRILL FOR USE		.00861		.009
	E		KAL-SM-F1	1.00	ROTARY FILE PER 1ST IN	USE	.00611		.007
0074	E		KAL-SM-F2	10.00	ROTARY FILE PER ADDL IN USE		.00459		.052
0080	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0508		JA 01	15	.79		NICK & BURR	.441	.052	.401
0010	E		RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316
0020	E		RLG-RS-N2	1.00	NICK & BURR LGE STRUT PARTS		.15614		.179
0030	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0521		JA 01	15	.79		POLISH CYL ID UPPER BORE	.497	.059	.452
0010	E		RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316
0020	E		ZPO-BP-C3	1.00	BUTTERFLY POLISH LRG CYL I.D	HONE/POLISH I.D.	.21256		.244
0030	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0610		JA 01	15	.08		MACH UPPER STEERING JOURNAL	3.130	.038	.288
0010					AFTER FLAME SPRAY				
0020	E		RML-SU-V3	.50	S/U VERT MIL BORE FXTR HOIST	PRORATE OP 610 & 615	1.03687		.596
0030	E		RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK		.22097		.254
0040	E		KML-TD-JC	2.00	DIA 5.00-6.00 REM .033-.250	11 IN. O.D.	.40208		.924
0050	E		KML-TD-JD	2.00	DIA 6.00 REM .250 ADD INCH	11 IN. O.D.	.24071		.553
0060	E		RLA-FR-NG	2.00	FACE ROUGH 9 - 10 DIA. GRP 4	11 IN. O.D. REMOVE F/SPRAY	.04424		.101
0070	E		RLA-FR-NH	2.00	FACE ROUGH 9 - 10 ADD 1/8 IN	11 IN. O.D. REMOVE F/SPRAY	.02050		.047
0080	E		RLA-FF-NG	2.00	FACE FINISH 9 - 10 GROUP 4	11 IN O.D. REMOVE F/SPRAY	.08910		.204
0090	E		RLA-FF-NH	2.00	FACE FINISH 9-10 ADD 1/8 IN.	11 IN O.D. REMOVE F/SPRAY	.04101		.094
0095	E		RLA-RC-NA	2.00	RECESS 6-6.5 DIA. 1/8 DP 61	11 IN. O.D. MACH RADIUS	.04670		.107
0110	E		RBW-SU-G1	.50	S/U FOR BENCH WORK GENERAL	PRORATE OP 610 & 615	.27525		.158
0111					REMOVE F/SPRAY FROM KEYWAYS				
0112					& OD OF FLANGE W/GRINDING MOTOR & FILE				
	E		KAL-SM-F1	1.00	ROTARY FILE PER 1ST IN	USE	.00611		.007
	E		KAL-SM-F2	102.00	ROTARY FILE PER ADDL IN USE	OCC FOR LENGTH	.00459		.538
0130	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011

	JA 01	15	.05		MACH LOWER STEERING JOURNAL	3.130	.023	.180
0				AFTER FLAME SPRAY				
.0	E	RML-SU-V3	.50	S/U VERT MIL BORE FXTR HOISTPRORATE OP 610 & 615		1.03687		.596
0030	E	RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK		.22097		.254
0040	E	KML-TD-JC	2.00	DIA 5.00-6.00 REM .033-.250 11 IN. O.D.		.40208		.924
0050	E	KML-TD-JD	2.00	DIA 6.00 REM .250 ADD INCH 11 IN. O.D.		.24071		.553
0060	E	RLA-FR-NG	2.00	FACE ROUGH 9 - 10 DIA. GRP 411 IN. O.D. REMOVE F/SPRAY		.04424		.101
0070	E	RLA-FR-NH	2.00	FACE ROUGH 9 - 10 ADD 1/8 IN11 IN. O.D. REMOVE F/SPRAY		.02050		.047
0080	E	RLA-FF-NG	2.00	FACE FINISH 9 - 10 GROUP 4 11 IN. O.D. REMOVE F/SPRAY		.08910		.204
0090	E	RLA-FF-NH	2.00	FACE FINISH 9-10 ADD 1/8 IN.11 IN. O.D. REMOVE F/SPRAY		.04101		.094
0095	E	RLA-RC-NA	2.00	RECESS 6-6.5 DIA. 1/8 DP G1 11 IN. O.D. MACH RADIUS		.04670		.107
0110	E	RBW-SU-G1	.50	S/U FOR BENCH WORK GENERAL PRORATE OP 610 & 615		.27525		.158
0111				REMOVE F/SPRAY FROM KEYWAYS				
0112				&OD OF FLANGE W/GRINDING MOTOR & FILE				
0114	E	KAL-SM-F1	1.00	ROTARY FILE PER 1ST IN USE		.00611		.007
0120	E	KAL-SM-F2	102.00	ROTARY FILE PER ADDL IN USE OCC FOR LENGTH		.00459		.538
0130	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0675	JA 01	15	.65		I/B TRIPOD BUSH INSTALLATION	.454	.044	.340
0010	E	RLA-SU-S3	.25	SET UP SMALL [illegible]UM LATHE	PRORATE OVER 4 PARTS	.49962		.143
0020	E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011
0030	E	KML-TA-DA	1.00	DIA 1.00-1.50 REMOVE (.033		.05535		.063
0035	E	KML-TA-DB	2.00	DIA 1.5 REMOVE .032 ADD INCH2 ADD INCHES		.00627		.014
0040	E	RLA-BO-CA	1.00	BORE HOLE 1 - 1 1/2 DIA 1 DP		.08663		.099
0045	E	RLA-BO-CB	2.00	BORE HOLE 1-1.5 DIA. ADD IN 2 ADD INCHES		.01254		.028
0050	E	RLA-FF-CA	1.00	FACE FINISH 1 - 1.5 GROUP 1 FACE TO LENGTH		.03023		.034
0055	E	RPL-AL-S1	1.00	ALODINE 1ST SMALL ALUM PART		.09953		.114
0090	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
	JA 01	15	.65		I/B TRIPOD BUSH INSTALLATION	.507	.049	.379
	E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053
0060	E	RBW-BU-B2	.50	REBUSH A SET OF 2 BOSSES	1 BUSHING	.22231		.127
0070	E	RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL	S/U TO HONE BUSH	.27525		.316
0080	M	ZHO-SU-S3	1.00		HAND HONE BUSHING(ADD TIME)	.06450		.074
0090	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0690	JA 01	15	.65		MACH BUSH O/B TRIPOD LUG	.819	.080	.613
0010	E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143
0020	E	RLA-HP-C1	3.00	1ST PART IN-OUT SCROLL CHUCK3 BUSHINGS		.01006		.034
0030	E	KML-TA-DA	3.00	DIA 1.00-1.50 REMOVE (.033	3 BUSHINGS	.05535		.190
0040	E	RLA-BO-CA	3.00	BORE HOLE 1 - 1 1/2 DIA 1 DP3 BUSHINGS		.08663		.298
0050	E	RLA-FF-CA	3.00	FACE FINISH 1 - 1.5 GROUP 1 FACE TO LENGTH		.03023		.104
0055	E	RPL-AL-S1	1.00	ALODINE 1ST SMALL ALUM PART		.09953		.114
0056	E	RPL-AL-S2	2.00	ALODINE EA ADD SMALL PART	2 ADD. BUSHINGS	.01927		.044
0080	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0700	JA 01	15	.65		O/B TRIPOD BUSH INSTALL	.729	.071	.546
0057	E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053
0058	E	RBW-BU-B2	1.50	REBUSH A SET OF 2 BOSSES	3 BUSHINGS	.22231		.383
0060	E	RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL	S/U TO HONE BUSHINGS	.27525		.316
0070	M	ZHO-SU-S3	1.00		HAND HONE BUSHINGS(ADD.TIME)	.06450		.074
0080	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0710	JA 01	15	.65		MACH BUSH LOWER TRIPOD LUG	1.021	.100	.763
0010	E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143
0020	E	RLA-HP-C1	4.00	1ST PART IN-OUT SCROLL CHUCK4 BUSHINGS		.01006		.046
0030	E	KML-TA-EA	4.00	DIA 1.50-2.00 REMOVE (.033	4 BUSHINGS	.05535		.254
0040	E	RLA-BO-DA	4.00	BORE HOLE 1 1/2 - 2 DIA 1 DP4 BUSHINGS		.08663		.398
	E	RLA-FF-DA	4.00	FACE FINISH 1.5 - 2 GROUP 1	FACE TO LENGTH 4 EA.	.03023		.139
	E	RPL-AL-S1	1.00	ALODINE 1ST SMALL ALUM PART		.09953		.114
0057	E	RPL-AL-S2	3.00	ALODINE EA ADD SMALL PART	3 ADD BUSHINGS	.01927		.066

90 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
	JA 01	15	.65	LOWER TRIPOD BUSH INSTALL	.841	.082	.629
0058 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053
0060 E		RBW-BU-B2	2.00 REBUSH A SET OF 2 BOSSES	4 BUSHINGS	.22231		.511
0070 E		RBW-SU-G1	1.00 S/U FOR BENCH WORK GENERAL	SU TO HONE BUSINGS	.27525		.316
0080 M		ZHO-SU-S3	1.00	HAND HONE BUSINGS (ADD.TIME)	.06450		.074
0090 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0730	JA 01	15	.65	MACH BUSH I/B ACT LUG	1.852	.181	1.385
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143
0020 E		RLA-HP-C1	4.00 1ST PART IN-OUT SCROLL CHUCK	4 BUSHINGS	.01006		.046
0030 E		KML-TA-EA	4.00 DIA 1.50-2.00 REMOVE (.033	4 BUSHINGS	.05535		.254
0040 E		RLA-BO-DA	4.00 BORE HOLE 1 1/2 - 2 DIA 1 DP	4 BUSHINGS	.08663		.398
0050 E		RLA-FF-DA	4.00 FACE FINISH 1.5 - 2 GROUP 1	FACE TO LENGTH 4 EA.	.03023		.139
0055 E		RPL-AL-S1	1.00 ALODINE 1ST SMALL ALUM PART		.09953		.114
0057 E		RPL-AL-S2	3.00 ALODINE EA ADD SMALL PART	3 ADD BUSHINGS	.01927		.066
0058 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053
0060 E		RBW-BU-B2	2.00 REBUSH A SET OF 2 BOSSES	4 BUSHINGS	.22231		.511
0070 E		RBW-SU-G1	1.00 S/U FOR BENCH WORK GENERAL	SU TO HONE BUSINGS	.27525		.316
0080 M		ZHO-SU-S3	1.00	HAND HONE BUSINGS (ADD.TIME)	.06450		.074
0090 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0740	JA 01	15	.93	I/B ACT BUSH INSTALLATION	.515	.072	.551
0065 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053
0070 E		RBW-BU-B1	.50 REBUSH A SET OF 2 BOSSES	1 BUSHING	.23835		.137
0080 E		RBW-SU-G1	1.00 S/U FOR BENCH WORK GENERAL	S/U TO HONE BUSHING	.27525		.316
0090 M		ZHO-SU-S3	1.00	HAND HONE BUSHING (ADD.TIME)	.06450		.074
0100 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
	JA 01	15	.93	MACH BUSH O/B ACTUATOR LUG	.587	.082	.628
) E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143
0015 E		RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK		.01006		.011
0020 E		KML-TD-DA	1.00 DIA 1.00-1.50 REMOVE (.033		.09677		.111
0030 E		RLA-BO-CG	1.00 BORE HOLE 1 - 1 1/2 DIA 1 DP		.17094		.196
0040 E		RLA-FR-CG	1.00 FACE ROUGH 1 - 1.5 DIA GRP 4	FACE FLANGE	.01810		.020
0050 E		RLA-FF-CG	1.00 FACE FINISH 1- 1.5 GROUP 4	FACE FLANGE	.03679		.042
0060 E		RLG-RS-B1	1.00 BRUSH PLATE SPOT OR HOLE	BRUSH PLATE BUSHING	.09546		.109
0070 E		KAL-MS-06	1.00 SEAL SPOT OR FASTENER- 1ST	INSTALL WITH SEALER	.02449		.028
0110 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0760	JA 01	15	.93	O/B ACT BUSH INSTALLATION	.515	.072	.551
0075 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053
0080 E		RBW-BU-B1	.50 REBUSH A SET OF 2 BOSSES	1 BUSHING	.23835		.137
0090 E		RBW-SU-G1	1.00 S/U FOR BENCH WORK GENERAL	S/U TO HONE BUSHING	.27525		.316
0100 M		ZHO-SU-S3	1.00	HAND HONE BUSHING (ADD.TIME)	.06450		.074
0110 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0770	JA 01	15	.93	MACH BUSH STEERING LUG	2.042	.285	2.184
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143
0015 E		RLA-HP-C1	4.00 1ST PART IN-OUT SCROLL CHUCK	4 BUSHINGS	.01006		.046
0020 E		KML-TD-EA	4.00 DIA 1.50-2.00 REM (.033	4 BUSHINGS	.11664		.536
0030 E		RLA-BO-CG	4.00 BORE HOLE 1 - 1 1/2 DIA 1 DP	4 BUSHINGS	.17094		.786
0040 E		RLA-FR-DG	4.00 FACE ROUGH 1.5 - 2 DIA GRP 4	FACE FLANGES	.01955		.089
0050 E		RLA-FF-DG	4.00 FACE FINISH 1.5 - 2 GROUP 4	FACE FLANGES	.03970		.182
0060 E		RLG-RS-B1	4.00 BRUSH PLATE SPOT OR HOLE	BRUSH PLATE 4 BUSHINGS	.09546		.439
0070 E		KAL-MS-06	4.00 SEAL SPOT OR FASTENER- 1ST	INSTALL WITH SEALER	.02449		.112
0110 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
	JA 01	15	.93	STEERING LUG BUSH INSTALL	.937	.131	1.003
E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053
0080 E		RBW-BU-B1	2.00 REBUSH A SET OF 2 BOSSES	2 SETS OF BUSHINGS	.23835		.548
0090 E		RBW-SU-G1	1.00 S/U FOR BENCH WORK GENERAL	S/U TO HONE BUSHINGS	.27525		.316

0100 N		ZHO-SU-S3	2.00		HONE 2 SETS OF BUSHINGS	.06450		.148
10 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
	JA 01	15	.10		CLEAN THRED HOLES	.413	.006	.048
0010 E		RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL	TAP HOLES 9 EA	.27525		.316
0020 E		GTL-TH-A1	9.00	TAP HOLE TO 0.25 IN THRD DIA	TAP HOLES	.01427		.147
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	SIGN PAPER	.01001		.011
0800	JA 01	15	.86		INSTALL HELICOILS	.486	.063	.481
0010 E		RBW-SU-H1	1.00	SET UP TO INSTALL HELICOILS		.31093		.357
0020 E		RBW-TR-H1	6.00	INSTALL HELICOIL INSERT	6 EA HELICOILS	.02763		.190
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0810	JA 01	15	.08		MACH BUSH DOOR ACTUATOR LUG	2.181	.026	.201
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE 4 PARTS	.49962		.143
0020 E		RLA-HP-C1	5.00	1ST PART IN-OUT SCROLL CHUCK	5 BUSHINGS	.01006		.057
0030 E		KML-TD-BA	5.00	DIA .251-.500 (.033	5 BUSHINGS	.06193		.356
0040 E		KML-CD-P1	5.00	CENTER DRILL	5 BUSHINGS	.01519		.087
0050 E		RLA-DR-TB	5.00	DRILL HOLE 1/8-1/4 DIA X 1	5 BUSHINGS	.08030		.461
0060 E		RLA-BO-AG	5.00	BORE HOLE (1/2 DIA 1 IN DP	5 BUSHINGS	.10123		.582
0070 E		RLA-FR-AG	5.00	FACE ROUGH (1/2 DIA. GRP. 4	5 BUSHINGS	.01487		.085
0080 E		RLA-FF-AG	5.00	FACE FINISH (1/2 DIA GRP 4	5 BUSHINGS	.03033		.174
0090 E		RLG-RS-B1	5.00	BRUSH PLATE SPOT OR HOLE	BRUSH PLATE 5 BUSHINGS	.09546		.548
0110 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0820	JA 01	15	.08		DOOR ACT LUG BUSH INSTALL	.612	.007	.056
0100 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053
0105 E		RBW-BU-B2	2.50	REBUSH A SET OF 2 BOSSES	5 BUSHINGS	.22231		.639
0110 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0840	JA 01	15	.43		MFG 2ND O/S ORIFICE BUSHING	1.558	.101	.771
0005 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE 4 PARTS	.49962		.143
0010 E		RLA-HP-C1	.20	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.002
E		KML-TD-DA	2.00	DIA 1.00-1.50 REMOVE (.033	2 BUSHINGS	.09677		.222
0020 E		KML-TD-DB	1.00	DIA 1.50 REM .033 ADD INCH	1 BUSHING	.03661		.042
0030 E		RLA-RC-DG	1.00	RECESS 1.5-2 DIA. 1/8 DP G4	MACH GROOVE 1 BUSHING	.06122		.070
0040 E		KML-CD-P1	2.00	CENTER DRILL	2 BUSHINGS	.01519		.034
0050 E		RLA-DR-VB	2.00	DRILL HOLE 1/2-2 DIA 1 DEEP	2 BUSHINGS	.12554		.288
0060 E		RLA-BO-BA	2.00	BORE HOLE 1/2 TO 1 DIA 1 DP	2 BUSHINGS	.08663		.199
0070 E		RLA-BO-BB	1.00	BORE HOLE 1/2 - 1 DIA ADD IN	1 BUSHING	.01254		.014
0080 E		RLA-FR-DG	2.00	FACE ROUGH 1.5 - 2 DIA GRP 4	2 BUSHINGS	.01955		.044
0090 E		RLA-FF-DG	2.00	FACE FINISH 1.5 - 2 GROUP 4	2 BUSHINGS	.03970		.091
0100 E		RLG-RS-B1	2.00	BRUSH PLATE SPOT OR HOLE	2 BUSHINGS	.09546		.219
0110 E		RHT-BE-S1	1.00	BAKE SMALL PART		.06868		.078
0115 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053
0120 E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES		.23835		.274
0130 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0900	JA 01	15	1.00			.000	.000	.000
0900				CLINTON BENTLEY TECH MANEL 3357				
9000	JA 01	00	.01		LABOR STANDARD HISTORY	.000	.000	.000
0010				PRIOR HISTORY ON OO-ALC 494 FORM				
0020				24FEB83 NEW OCC. FACTOR STUDY 9.45				
0021				31JUL84 REWRITE STD W/NEW OCC FACTORS<OLD STD>8.83				
0022				23JUL85 NEW OCC FACTORS & REVIEW <OLD STD> 9.39				
0023				25AUG86-MOVED SUBOPS 0140 TO 504--0160 TO 0504--				
0024				0520 TO 0508--0510 TO 0521--OLD STD WAS 12.03				
0025				20 FEB 87 NEW OCC FACTORS & REVIEW OLD STD 9.99				
0026								
				23 SEPT 87 ADDED SUB OPS 425,460,470,480,490,500				
				AND 502 NOT ON 958 ADDED TO REQ OLD STD 15.32				
0027				21OCT87 DROPED SUBOP 0220 NO LONGER IN TO 9.09				

SUB [illegible]	T K #R A FA SUPPORT OCC	D L K C DC ELEMENT FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
32	S E JA EA 1 J 88229	.83	PERCENT ENGR 97.5	MACH INNER CYL B52M	4.44		3.68	
0001	JA 01 00	.00		PART NUMBER/NSN	.000	.000	.000	0
0010			5-85123-6	1620006582588				
0100	JA 01 15	.50		BRAKE MOUNTING HOLE REP	1.051	.079	.605	14
0020	E RML-SU-V3	.50	S/U VERT MIL BORE FXTR HOIST	PRORATE OVER 2 OPERATIONS	1.03687		.596	
0030	E RML-HP-CD	.50	HOIST HANDLE WRAPPED 2 CLAMP	PRORATE OVER 2 OPERATIONS	.18155		.104	
0040	E RML-AL-AA	1.00	ALIGN HORIZ AXIS ROD		.06265		.072	
0041	E RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0050	E RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0060	N	1.00		CUT SLOT	.16700		.192	
0070	E RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0120	JA 01 15	.05		REPAIR JACKPAD BOSS	1.462	.011	.084	2
0010	E RML-SU-V3	.50	S/U VERT MIL BORE FXTR HOIST	PRORATE OVER 2 OPERATIONS	1.03687		.596	
0015	E RML-HP-CD	.50	HOIST HANDLE WRAPPED 2 CLAMP	PRORATE OVER 2 OPERATIONS	.18155		.104	
0018	E RML-AL-AA	1.00	ALIGN HORIZ AXIS ROD		.06265		.072	
0020	E RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0030	E RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0040	E RML-BD-GB	1.00	BORE HOLE 4 X 1 GROUP 4		.57729		.663	
0050	E RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0140	JA 01 15	.05		WELD SPLATER REWORK	.404	.003	.023	1
0010	E RBW-SU-G1	.50	S/U FOR BENCH WORK GENERAL	PRORATED 2 EA AREAS OF REWRK	.27525		.158	
0020	E GTL-EP-A2	1.00	SET UP & DISMANTLE AIR DRILL		.00678		.007	
0030	N	1.00		REMOVE WELD SPLATTER	.25000		.287	
0040	E RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
[illegible]	JA 01 15	.05		REP RETAIN NUTLOCK BOLT HOLE	.454	.003	.026	1
	E RDR-SU-R1	.20	S/U TO O/S BOSSES RAD DRILL	PRORATE OVER 5 OPERATIONS	.56378		.129	
0015	E RML-HP-CD	.20	HOIST HANDLE WRAPPED 2 CLAMP	PRORATE OVER 5 OPERATIONS	.18155		.041	
0020	E RML-AL-AC	3.00	ALIGN HOLE TO SPINDLE ROD	3 HOLES	.07609		.262	
0030	E KAL-SM-31	1.00	SPOT-FACE OR COUNTERBORE	SPOTFACE HOLE	.02004		.023	
0035	E KOH-RP-AC	2.00	REPOSITION OBJECT 80-130 LBS	REPOSITION FOR 2 MORE HOLES	.00369		.008	
0040	E KAL-SM-31	2.00	SPOT-FACE OR COUNTERBORE	2 EA ADD HOLES SPOTFACED	.02004		.046	
0050	E RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0160	JA 01 15	.47		REP RETAIN NUTLOCK BOLT HOLE	.454	.032	.246	6
0010	E RDR-SU-R1	.20	S/U TO O/S BOSSES RAD DRILL	PRORATE OVER 5 OPERATIONS	.56378		.129	
0015	E RML-HP-CD	.20	HOIST HANDLE WRAPPED 2 CLAMP	PRORATE OVER 5 OPERATIONS	.18155		.041	
0020	E RML-AL-AC	3.00	ALIGN HOLE TO SPINDLE ROD	3 HOLES	.07609		.262	
0030	E KAL-SM-31	1.00	SPOT-FACE OR COUNTERBORE	SPOTFACE HOLE	.02004		.023	
0035	E KOH-RP-AC	2.00	REPOSITION OBJECT 80-130 LBS	REPOSITION FOR 2 MORE HOLES	.00369		.008	
0040	E KAL-SM-31	2.00	SPOT-FACE OR COUNTERBORE	2 EA ADD HOLES SPOTFACED	.02004		.046	
0050	E RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0165	JA 01 15	.47		REP RETAIN NUTLOCK BOLT HOLE	.454	.032	.246	6
0010	E RDR-SU-R1	.20	S/U TO O/S BOSSES RAD DRILL	PRORATE OVER 5 OPERATIONS	.56378		.129	
0015	E RML-HP-CD	.20	HOIST HANDLE WRAPPED 2 CLAMP	PRORATE OVER 5 OPERATIONS	.18155		.041	
0020	E RML-AL-AC	3.00	ALIGN HOLE TO SPINDLE ROD	3 HOLES	.07609		.262	
0030	E KAL-SM-31	1.00	SPOT-FACE OR COUNTERBORE	SPOTFACE HOLE	.02004		.023	
0035	E KOH-RP-AC	2.00	REPOSITION OBJECT 80-130 LBS	REPOSITION FOR 2 MORE HOLES	.00369		.008	
0040	E KAL-SM-31	2.00	SPOT-FACE OR COUNTERBORE	2 EA ADD HOLES SPOTFACED	.02004		.046	
0050	E RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0220	JA 01 15	.62		O/S TORQUE ARM LUG	1.252	.116	.893	20
[illegible]	E AJP-TO-01	1.00	T.O.RESEARCH		.03471		.039	
	RDR-SU-R1	.20	S/U TO O/S BOSSES RAD DRILL	PRORATE OVER 5 OPERATIONS	.56378		.129	
[illegible]	E RML-HP-CD	.20	HOIST HANDLE WRAPPED 2 CLAMP	PRORATE OVER 5 OPERATIONS	.18155		.041	
0037	E RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	

		RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL			.30463		.350	
[illegible]	E	RDR-BO-A2	1.00	O/S ADML BOSS STP RMR RAD DR			.14687		.168	
0060	E	KOH-RP-AC	1.00	REPOSITION OBJECT 80-130 LBSTURN PART 180 %			.00369		.004	
0065	E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD			.07609		.087	
0070	E	RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL			.30463		.350	
[illegible]0	E	RDR-BO-A2	1.00	O/S ADML BOSS STP RMR RAD DR			.14687		.168	
[illegible]	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
[illegible]	JA 01	15	.25		TOW LUG 1ST O/S		.964	.036	.277	6
0010	E	RDR-SU-R1	.20	S/U TO O/S BOSSES RAD DRILL	PRORATE OVER 5 OPERATIONS		.56378		.129	
0015	E	RML-HP-CD	.20	HOIST HANDLE WRAPPED 2 CLAMP	PRORATE OVER 5 OPERATIONS		.18155		.041	
0020	E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD			.07609		.087	
0030	E	RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL			.30463		.350	
0040	E	KAL-SM-31	1.00	SPOT-FACE OR COUNTERBORE			.02004		.023	
0050	E	KOH-RP-AC	1.00	REPOSITION OBJECT 80-130 LBSTURN PART 180 %			.00369		.004	
0060	E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD			.07609		.087	
0070	E	RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL			.30463		.350	
0080	E	KAL-SM-31	1.00	SPOT-FACE OR COUNTERBORE			.02004		.023	
0090	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0260	JA 01	15	.08		TOW LUG 2ND O/S		.954	.011	.088	2
0010	E	RDR-SU-R1	.20	S/U TO O/S BOSSES RAD DRILL	PRORATE OVER 5 OPERATIONS		.56378		.129	
0015	E	RML-HP-CD	.20	HOIST HANDLE WRAPPED 2 CLAMP	PRORATE OVER 5 OPERATIONS		.18155		.041	
0020	E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD			.07609		.087	
0030	E	RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL			.30463		.350	
0040	E	KAL-SM-31	1.00	SPOT-FACE OR COUNTERBORE			.02004		.023	
0050	E	KOH-RP-AC	1.00	REPOSITION OBJECT 80-130 LBSTURN PART 180 %			.00369		.004	
0060	E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD			.07609		.087	
0070	E	RDR-BO-A1	1.00	O/S BOSS W/STEP RMR RAD DRL			.30463		.350	
0075	E	KAL-SM-31	1.00	SPOT-FACE OR COUNTERBORE			.02004		.023	
0270	JA 01	15	.05		MACH HYD FITTING HOLES		1.948	.015	.112	3
0010	E	RML-SU-V3	.50	S/U VERT MIL BORE FXTR HOIST	PRORATE 2 PARTS		1.03687		.596	
0020	E	RML-HP-CD	1.00	HOIST HANDLE WRAPPED 2 CLAMP			.18155		.208	
[illegible]4	E	RML-AL-AA	1.00	ALIGN HORIZ AXIS ROD	ALIGN HORIZ		.06265		.072	
	E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD			.12699		.146	
0035	E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD			.07609		.087	
0040	E	RML-BD-AA	1.00	BORE HOLE 1 X 1/2 GROUP 4	SPOTFACE 1ST HOLE		.27100		.311	
0045	E	KOH-RP-AC	1.00	REPOSITION OBJECT 80-130 LBS	REPOSITION TO 2ND HOLE		.00369		.004	
0050	E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	2ND HOLE		.07609		.087	
0060	E	RML-BD-AA	1.00	BORE HOLE 1 X 1/2 GROUP 4	SPOTFACE 2ND HOLE		.27100		.311	
0070	E	KOH-RP-AC	1.00	REPOSITION OBJECT 80-130 LBS	REPOSITION TO 3RD HOLE		.00369		.004	
0080	E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD			.07609		.087	
0090	E	RML-BD-AA	1.00	BORE HOLE 1 X 1/2 GROUP 4	SPOTFACE 3RD HOLE		.27100		.311	
0100	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0272	JA 01	15	.05		MACH CRACK AXLE THREAD AREA		1.354	.010	.078	2
0010	E	RML-SU-V3	.50	S/U VERT MIL BORE FXTR HOIST	PRORATE 2 PARTS		1.03687		.596	
0020	E	RML-HP-CD	1.00	HOIST HANDLE WRAPPED 2 CLAMP			.18155		.208	
0030	E	RML-AL-AA	1.00	ALIGN HORIZ AXIS ROD			.06265		.072	
0040	E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD			.12699		.146	
0050	E	RML-BD-AA	1.00	BORE HOLE 1 X 1/2 GROUP 4	MACH W/BALL END MILL		.27100		.311	
0060	E	RBW-SU-G1	.50	S/U FOR BENCH WORK GENERAL	PRORATE 2 PARTS		.27525		.158	
0070	E	RLG-RS-N4	1.00	NICK & BURR SMALL STRUT PART	FILE THREAD AREA & POLISH		.04595		.052	
0080	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0940	JA 01	15	1.00		TURN BUSHING GROUP 4/STEEL		.399	.060	.459	10
0010	E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143	
0020	E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.011	
0030	E	KML-TD-EC	1.00	DIA 1.50-2.00 REM .033-.250			.17225		.198	
0040	E	KML-TD-ED	1.00	DIA 2.00 REM .250 ADD INCH			.08233		.094	
0050	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
[illegible]	JA 01	15	1.00		INST STRAIGHT BUSH NO POLISH		.077	.012	.089	2
	E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053	
0020	E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING			.02062		.023	

		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
	JA 01	15	1.00		TURN BUSHING GROUP 1/BRONZE		.211	.032	.244	5
0010	E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143	
0020	E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.011	
0030	E	KML-TA-EC	1.00	DIA 1.50-2.00 REM .033-.250			.06699		.077	
0040	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
	JA 01	15	1.00		INST/REAM SET STRAIGHT BUSH		.278	.042	.321	7
.0	E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053	
0020	E	RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH		.22231		.255	
0030	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0959	JA 01	15	1.00		TURN BUSHING GROUP 1/BRONZE		.289	.043	.332	7
0010	E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143	
0020	E	RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS		.01006		.023	
0030	E	KML-TA-EC	2.00	DIA 1.50-2.00 REM .033-.250			.06699		.154	
0040	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0960	JA 01	15	1.00		INST/REAM SET STRAIGHT BUSH		.278	.042	.321	7
0010	E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053	
0020	E	RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH		.22231		.255	
0030	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
9000	JA 01	15	.01		LABOR STANDARD HISTORY		.000	.000	.000	0
0010				PRIOR HISTORY ON OO-ALC 494 FORM						
0020				24FEB83 OCC. FACTOR STUDY UPDATE		4.28				
0021				31JUL84 REWRITE STD W/NEW OCC FACTORS<OLD STD>3.76						
0022				10AUG84 ADD SUB O/P 0272-OCC ESTIMATE<OLD STD>4.81						
0023				23JUL85 NEW OCC FACTORS & REVIEW <OLD STD>		4.96				
0024				19 FEB 87 NEW OCC FACTORS & REVIEW OLD STD		4.93				
0900				CLINTON BENTLEY TECH MANEL 3357						

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 05/12/89 A-E046B-MM1-DY-M45 PAG

17143A STRUT B-52 MLG RCC MNPRA 4S1-57-3

SUB STEP	ECH S S T K D L	W F PF A/R REV R A FA C DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DL
RA004	S E	JA EA 1 J	85204	.63	PERCENT ENGR 99.9	MACH STEER BEAR OCC.2EA 604	.91		.57	
0001		JA 01 00		.00		PART NUMBER/NSN	.000	.000	.000	
0010					9-52299-505	1620009665426				
0020					9-52532-501	1620009072897				
0020		JA 01 15		1.00		DRILL & C/SINK STEER BRGNS	.704	.106	.810	
0010	E		RDR-SU-V1	.33	S-U DR PRS W-VISE FIXT DV-HDPRORATE OP 020.040 & 060		.42803		.162	
0020	E		RLA-DR-BA	12.00	DRILL HOLE 1/16-1/8 DIA (1/212 EA HOLES		.04188		.577	
0030	E		KAL-SM-C1	1.00	COUNTERSINK HOLE TO 1/4 INCH		.00205		.002	
0040	E		KAL-SM-C2	11.00	COUNTERSINK ADDL HOLE 1/4 IN11 EA HOLES		.00104		.013	
0050	E		KTL-DB-A1	1.00	DEBURR HOLE FIRST BOTH SIDES		.00449		.005	
0060	E		KTL-DB-A2	11.00	DEBURR HOLE ADDL BOTH SIDES 11 EA HOLES		.00294		.037	
0070	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0080		JA 01 15		.06		RADIUS STEERING BEARING	.705	.006	.049	
0010	E		RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
0015	E		GTL-EP-A2	1.00	SET UP & DISMANTLE AIR DRILL		.00678		.007	
0020	E		KAL-SM-F1	64.00	ROTARY FILE PER 1ST IN	USE 8 TIMES X 8 CORNERS	.00611		.449	
0025	E		GID-SA-A1	1.00	STAMP WITH METAL STAMP		.00342		.003	
0027	E		GID-SA-A2	10.00	STAMP W/METAL STAMP ADDL	10 ADD. NUMBERS	.00187		.021	
0030	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0160		JA 01 15		1.00		MATCH DRL GEAR TO LOWER BRG	.050	.008	.058	
0010	E		RSG-JP-03	.25	PREP HAND DRILL FOR USE	PRORATED OVER 4 PARTS	.00861		.002	
0020	E		GTL-DD-A4	2.00	DRILL HOLE W/PORTABLE DRILL	DRILL 2 HOLES	.00924		.021	
0030	E		KAL-SM-31	1.00	SPOT-FACE OR COUNTERBORE	,	.02004		.023	
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC.		.01001		.011	
9000		JA 01 15		.01		LABOR STANDARD HISTORY	.000	.000	.000	
0010					PRIOR HISTORY ON 00-ALC 494 FORM					
0020					24FEB83 NEW OCC. FACTOR STUDY	.38				
0021					31JUL84 REWRITE STD W/NEW OCC FACTORS<OLD STD>	.28				
0022					23JUL85 NEW OCC FACTORS & REVIEW <OLD STD>	.68				
0023					02APR86 DELETE SUB OP 0040,0060	<OLD STD>.54				
0024					02APR86 CHG SUBOP 0020 TO 100% EST TIL NEXT STUDY					
0900					MANEL CLINTON BENTLEY MRP II 7-3255					

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OPER SUB	TECH STEP	S D	S L	W R K	F A C	PF DC	A/R ELEMENT	REV SUPPORT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY
RA005		S	E	JA	EA	1	J	85204	1.00	PERCENT ENGR 99.9	REP LOWER TRIPOD LINK 507	8.93		8.93	
0001				JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000	
	0010									25-4211	1620006099886				
0070				JA	01	15			.05		REMOVE BUSHINGS	.335	.003	.019	
	0010	E				RBW	SU	G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
	0030	E				RLG	RS	KB	6.00	K/O SINGLE BUSH 1-3 IN DIA	OCC FOR 6 BUSHINGS	.00836		.057	
	0050	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0100				JA	01	15			.60		MACH LUG "G"	1.484	.134	1.024	
	0010	E				RML	SU	T1	.50	SET UP TOBIN ARP BORING MACH	PRORATE "G" & "H" LUGS	.80267		.461	
	0020	E				RML	HP	AA	1.00	HAND HANDLE NORAP SIMPL FXTR		.05454		.062	
	0025	E				RML	AL	AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
	0030	E				RML	BD	BA	2.00	BORE HOLE 1.5 X 1/2 GROUP 4	2 LUGS 1/2 LONG	.29250		.672	
	0040	E				RML	BD	BB	1.00	BORE HOLE 1.5 X 1 GROUP 4	1 LUG 1 IN LONG	.35729		.410	
	0050	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0120				JA	01	15			.60		MACHINE LUG "H"	1.613	.145	1.114	
	0010	E				RML	SU	T1	.50	SET UP TOBIN ARP BORING MACH	PRORATE "G" & "H" LUGS	.80267		.461	
	0020	E				RML	HP	AA	1.00	HAND HANDLE NORAP SIMPL FXTR		.05454		.062	
	0025	E				RML	AL	AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
	0030	E				RML	BD	BB	3.00	BORE HOLE 1.5 X 1 GROUP 4	3 LUGS	.35729		1.232	
	0040	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0219				JA	01	15			.82		MACH BUSH LUG G	1.666	.205	1.572	
	0010	E				RLA	SU	S3	.50	SET UP SMALL MEDIUM LATHE	PRORATE "G" & "H" LUGS	.49962		.287	
	0020	E				RLA	HP	C5	3.00	PUT PART IN & OUT OF COLLET	3 BUSHINGS	.00642		.022	
	0030	E				KML	TD	EA	3.00	DIA 1.50-2.00 REM (.033	3 BUSHINGS	.11664		.402	
	0040	E				RLA	BO	DG	3.00	BORE HOLE 1 1/2 - 2 DIA 1 DP	3 BUSHINGS	.21069		.726	
	0050	E				RLA	FF	DG	3.00	FACE FINISH 1.5 - 2 GROUP 4	3 BUSHINGS	.03970		.136	
	0060	E				RLG	RS	B1	3.00	BRUSH PLATE SPOT OR HOLE	BRUSH PLATE 3 BUSHINGS	.09546		.329	
	0080	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0220				JA	01	15			.82		INSTALL BUSHING LUG "G"	.165	.020	.156	
	0065	E				RBW	BU	S1	.50	SET UP TO REBUSH BOSSES	PRORATE OVER "G" & "H" LUGS	.18669		.107	
	0070	E				RBW	BU	A4	3.00	INSTALL ONE STRAIGHT BUSHING	3 BUSHINGS	.02062		.071	
	0080	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0225				JA	01	15			.82		FINISH LINE REAM OR HONE	1.408	.173	1.328	
	0075	E				RML	SU	T1	.50	SET UP TOBIN ARP BORING MACH	PRORATE "G" & "H" LUGS	.80267		.461	
	0076	E				RML	HP	AA	1.00	HAND HANDLE NORAP SIMPL FXTR		.05454		.062	
	0077	E				RML	BD	BA	2.00	BORE HOLE 1.5 X 1/2 GROUP 4	1 BUSH 1/2 LONG	.29250		.672	
	0078	E				RML	BD	BB	1.00	BORE HOLE 1.5 X 1 GROUP 4	1 BUSH 1 INCH LONG	.35729		.410	
	0080	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0235				JA	01	15			1.00		MACH BUSH LUG H	1.666	.250	1.917	
	0010	E				RLA	SU	S3	.50	SET UP SMALL MEDIUM LATHE	PRORATE "G" & "H" LUGS	.49962		.287	
	0020	E				RLA	HP	C5	3.00	PUT PART IN & OUT OF COLLET	3 BUSHINGS	.00642		.022	
	0030	E				KML	TD	EA	3.00	DIA 1.50-2.00 REM (.033	3 BUSHINGS	.11664		.402	
	0040	E				RLA	BO	DG	3.00	BORE HOLE 1 1/2 - 2 DIA 1 DP	3 BUSHINGS	.21069		.726	
	0050	E				RLA	FF	DG	3.00	FACE FINISH 1.5 - 2 GROUP 4	3 BUSHINGS	.03970		.136	
	0060	E				RLG	RS	B1	3.00	BRUSH PLATE SPOT OR HOLE	BRUSH PLATE 3 BUSHINGS	.09546		.329	
	0080	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	

[illegible]	JA 01	15	1.00		INSTALL BUSHING LUG "H"	.165	.025	.190
5	E	RBW-BU-S1	.50	SET UP TO REBUSH BOSSES	PRORATE OVER "G" & "H" LUGS	.18669		.107
,0	E	RBW-BU-A4	3.00	INSTALL ONE STRAIGHT BUSHING	3 BUSHINGS	.02062		.071
0080	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0245	JA 01	15	1.00		FINISH LINE REAM OR HONE	1.408	.211	1.619
0075	E	RML-SU-T1	.50	SET UP TOBIN ARP BORING MACH	PRORATE "G" & "H" LUGS	.80267		.461
0076	E	RML-HP-AA	1.00	HAND HANDLE NORAP SIMPL FXTR		.05454		.062
0077	E	RML-BD-BA	2.00	BORE HOLE 1.5 X 1/2 GROUP 42	BUSH 1/2 LONG	.29250		.672
0078	E	RML-BD-BB	1.00	BORE HOLE 1.5 X 1 GROUP 4	1 BUSH 1 IN LONG	.35729		.410
0080	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
9000	JA 01	15	.01		LABOR STANDARD HISTORY	.000	.000	.000
0010				PRIOR HISTORY ON OO-ALC 494 FORM				
0020				24FEB83 NEW OCC. FACTOR STUDY	4.34			
0021				31JUL84 REWRITE STD W/NEW OCC FACTORS<OLD STD>	3.72			
0022				23JUL85 NEW OCC FACTORS & REVIEW <OLD STD>	6.68			
0023				19 FEB 87 NEW OCC FACTORS & REVIEW OLD STD	7.61			
0900				CLINTON BENTLEY TECH MANEL 3357				

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OPER SUB STEP	TECH D	S L	S K	W #R	F A	PF C	A/R FA	REV DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY
RA006	S	E	JA	EA	1		J	85204	1.00	PERCENT ENGR 96.6		REP OUTBOARD LINK B52M 507	8.24		8.24	
0001			JA	01	00				.00			PART NUMBER/NSN	.000	.000	.000	
0010										5-36035-3		1620006207642				
0080			JA	01	15				.15			REMOVE BUSHINGS	.318	.007	.055	
0010	E				RBW-SU-G1				1.00	S/U FOR BENCH WORK GENERAL			.27525		.316	
0030	E				RLG-RS-KB				4.00	K/O SINGLE BUSH 1-3 IN DIA	OCC FOR 7EA BUSHINGS		.00836		.038	
0050	E				RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0100			JA	01	15				.15			O/S LUG "A"	.701	.016	.121	
0010	E				RML-SU-T1				.25	SET UP TOBIN ARP BORING MACHPRORATE OVER 4 PARTS			.80267		.230	
0020	E				RML-HP-AA				1.00	HAND HANDLE NORAP SIMPL FXTR			.05454		.062	
0030	E				RML-AL-AC				1.00	ALIGN HOLE TO SPINDLE ROD			.07609		.087	
0040	E				RML-BC-BD				1.00	BORE HOLE 1.5 X 2 GROUP 3			.36029		.414	
0050	E				RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0120			JA	01	15				.59			O/S LUG "B"	1.050	.093	.713	
0010	E				RML-SU-V2				.25	S/U VERT MILL BORE LRG FIXTR1 OF 4 LUGS			.80167		.230	
0020	E				RJP-TC-A2				.25	FIXT TO & FROM STORAGE ROOM 1 OF 4 LUGS			.20388		.058	
0030	E				RML-HP-CA				.25	HAND HANDLE NO WRAP 2 CLAMPS1 OF 4 LUGS			.08531		.024	
0040	E				RML-AL-BB				1.00	ALIGN VERTICAL AXIS CLAMP			.11975		.137	
0050	E				RML-AL-BA				1.00	ALIGN HORIZ AXIS CLAMP			.05541		.063	
0060	E				RML-AL-AC				1.00	ALIGN HOLE TO SPINDLE ROD			.07609		.087	
70	E				RML-BC-CF				1.00	BORE HOLE 2 X 3 GROUP 3			.51647		.593	
80	E				RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0140			JA	01	15				.42			O/S LUG "C"	1.128	.071	.545	
0010	E				RML-SU-V2				.25	S/U VERT MILL BORE LRG FIXTR1 OF 4 LUGS			.80167		.230	
0020	E				RJP-TC-A2				.25	FIXT TO & FROM STORAGE ROOM 1 OF 4 LUGS			.20388		.058	
0030	E				RML-HP-CA				.25	HAND HANDLE NO WRAP 2 CLAMPS1 OF 4 LUGS			.08531		.024	
0040	E				RML-AL-BB				1.00	ALIGN VERTICAL AXIS CLAMP			.11975		.137	
0050	E				RML-AL-BA				1.00	ALIGN HORIZ AXIS CLAMP			.05541		.063	
0060	E				RML-AL-AC				1.00	ALIGN HOLE TO SPINDLE ROD			.07609		.087	
0070	E				RML-BC-DF				1.00	BORE HOLE 2.5 X 3 GROUP 3			.59423		.683	
0080	E				RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0160			JA	01	15				.59			O/S LUG "D"	.855	.076	.580	
0010	E				RML-SU-V2				.25	S/U VERT MILL BORE LRG FIXTR1 OF 4 LUGS			.80167		.230	
0020	E				RJP-TC-A2				.25	FIXT TO & FROM STORAGE ROOM 1 OF 4 LUGS			.20388		.058	
0030	E				RML-HP-CA				.25	HAND HANDLE NO WRAP 2 CLAMPS1 OF 4 LUGS			.08531		.024	
0040	E				RML-AL-BB				1.00	ALIGN VERTICAL AXIS CLAMP			.11975		.137	
0050	E				RML-AL-BA				1.00	ALIGN HORIZ AXIS CLAMP			.05541		.063	
0060	E				RML-AL-AC				1.00	ALIGN HOLE TO SPINDLE ROD			.07609		.087	
0070	E				RML-BC-BC				1.00	BORE HOLE 1.5 X 1.5 GROUP 3			.32109		.369	
0080	E				RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0259			JA	01	15				.92			MACH BUSH LUG "B"	1.072	.148	1.135	
0010	E				RLA-SU-S3				.25	SET UP SMALL MEDIUM LATHE	PRORATE 4 LUGS		.49962		.143	
0020	E				RLA-HP-C5				2.00	PUT PART IN & OUT OF COLLET	2 BUSHINGS		.00642		.014	
0030	E				KML-TD-EA				2.00	DIA 1.50-2.00 REM (.033	2 BUSHINGS		.11664		.268	
0040	E				RLA-BO-DG				2.00	BORE HOLE 1 1/2 - 2 DIA 1 DP	2 BUSHINGS		.21069		.484	
0050	E				RLA-FF-DG				2.00	FACE FINISH 1.5 - 2 GROUP 4	2 BUSHINGS		.03970		.091	
0	E				RLG-RS-B1				2.00	BRUSH PLATE SPOT OR HOLE	2 BUSHINGS		.09546		.219	
.0	E				RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0260			JA	01	15				.92			INSTALL BUSH LUG "B"	.079	.011	.084	

0070	E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE 4 LUGS	.18669		.053
0080	E		RBW-BU-A2	1.00	INSTALL SET STRAIGHT BUSHING		.02299		.026
10	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
		JA 01	15	.92		FINISH HONE LUG "B" BUSH	.299	.041	.316
0090	E		RDR-SU-R1	.33	S/U TO O/S BOSSES RAD DRILL	PRORATE 3 LUGS	.56378		.213
0100	E		ZPO-BU-01	1.00		HONE BUSHINGS TO SIZE	.10304		.118
0110	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0275		JA 01	15	.92		MACH BUSH LUG "C"	1.218	.168	1.289
0010	E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE 4 LUGS	.49962		.143
0020	E		RLA-HP-C5	2.00	PUT PART IN & OUT OF COLLET	2 BUSHINGS	.00642		.014
0030	E		KML-TD-FA	2.00	DIA 2.00-3.00 REMOVE (.033	2 BUSHINGS	.14659		.337
0035	E		RLA-BO-EG	2.00	BORE HOLE 2 - 2 1/2 DIA 1 DP	2 BUSHINGS	.25045		.576
0040	E		RLA-FF-EG	2.00	FACE FINISH 2 - 2.5 GROUP 4	2 BUSHINGS	.04293		.098
0050	E		RLG-RS-B1	2.00	BRUSH PLATE SPOT OR HOLE	2 BUSHINGS	.09546		.219
0100	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0280		JA 01	15	.92		INSTALL BUSH LUG "C"	.079	.011	.084
0060	E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE 4 LUGS	.18669		.053
0070	E		RBW-BU-A2	1.00	INSTALL SET STRAIGHT BUSHING		.02299		.026
0100	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0285		JA 01	15	.92		FINISH HONE LUG "C" BUSH	.299	.041	.316
0080	E		RDR-SU-R1	.33	S/U TO O/S BOSSES RAD DRILL	PRORATE 3 LUGS	.56378		.213
0090	E		ZPO-BU-01	1.00		HONE BUSHINGS TO SIZE	.10304		.118
0100	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0295		JA 01	15	.84		MACH BUSH LUG "D"	.541	.068	.523
0010	E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE 4 LUGS	.49962		.143
0020	E		RLA-HP-C5	1.00	PUT PART IN & OUT OF COLLET		.00642		.007
0030	E		KML-TD-DA	1.00	DIA 1.00-1.50 REMOVE (.033		.09677		.111
040	E		RLA-BO-CG	1.00	BORE HOLE 1 - 1 1/2 DIA 1 DP		.17094		.196
50	E		RLA-FF-CG	1.00	FACE FINISH 1- 1.5 GROUP 4		.03679		.042
060	E		RLG-RS-B1	1.00	BRUSH PLATE SPOT OR HOLE	BRUSH PLATE BUSHING	.09546		.109
0110	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0300		JA 01	15	.84		INSTALL BUSH LUG "D"	.077	.010	.075
0070	E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE 4 LUGS	.18669		.053
0080	E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023
0110	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
030		JA 01	15	.84		FINISH HONE LUG "D" BUSH	.299	.038	.289
0090	E		RDR-SU-R1	.33	S/U TO O/S BOSSES RAD DRILL	PRORATE 3 LUGS	.56378		.213
0100	E		ZPO-BU-01	1.00		HONE BUSHING TO SIZE	.10304		.118
0110	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0310		JA 01	15	1.00		MACH BUSH LUG "A"	.947	.142	1.090
0010	E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE 4 LUGS	.49962		.143
0020	E		RLA-HP-C5	2.00	PUT PART IN & OUT OF COLLET	2 BUSHINGS	.00642		.014
0030	E		KML-TD-DA	2.00	DIA 1.00-1.50 REMOVE (.033	2 BUSHINGS	.09677		.222
0040	E		RLA-BO-CG	2.00	BORE HOLE 1 - 1 1/2 DIA 1 DP	2 BUSHINGS	.17094		.393
0050	E		RLA-FF-CG	2.00	FACE FINISH 1- 1.5 GROUP 4	2 BUSHINGS	.03679		.084
0060	E		RLG-RS-B1	2.00	BRUSH PLATE SPOT OR HOLE	2 BUSHINGS	.09546		.219
0130	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0901					K.HANSEN TECH.				
0320		JA 01	15	1.00		INSTALL BUSH LUG "A"	.079	.012	.092
0070	E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE 4 LUGS	.18669		.053
0080	E		RBW-BU-A2	1.00	INSTALL SET STRAIGHT BUSHING		.02299		.026
0130	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		011
0901					K.HANSEN TECH.				
		JA 01	15	1.00		FINISH HONE LUG "A" BUSH	.815	.122	.938
090	E		RDR-SU-R1	1.00	S/U TO O/S BOSSES RAD DRILL		.56378		.648
0100	M			1.00		HONE BUSHING TO SIZE	.24200		.278

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0130 E          RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                    .01001          .011
 701                                K.HANSEN TECH.
      JA 01   15          .01                          LABOR STANDARD HISTORY    .000   .000     .000
0010                          PRIOR HISTORY ON OO-ALC 494 FORM
0020                          24FEB83 NEW OCC. FACTOR STUDY                4.24
0021                          31JUL84 REWRITE STD W/NEW OCC FACTORS<OLD STD>4.13
0022                          23JUL85 NEW OCC FACTORS & REVIEW<OLD STD>    6.14
0023                          19 FEB 87 NEW OCC FACTORS & REVIEW OLD STD    6.20
0900                          CLINTON BENTLEY TECH MANEL 3357


TG INTERROGATE LABOR STANDARDS. INPUT

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OPER SUB STEP	TECH D	S L	S K	W #R K	F A C	PF FA DC	A/R SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY
RA007	S	E	JA	EA	1		J 85204	.96	PERCENT ENGR 95.4	REP I/B TRIPOD LINK 507	3.20		3.07	
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000	
0010									5-35964-3	1620000922837				
0070			JA	01	15			.05		REMOVE BUSHINGS	.418	.003	.024	
0010	E				RBW-SU-G1			1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
0020	E				RHT-BE-L1			1.00	BAKE LARGE PART		.11699		.134	
0030	E				RLG-RS-KB			2.00	K/O SINGLE BUSH 1-3 IN DIA	OCC FOR 4EA BUSHING	.00836		.019	
0050	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0100			JA	01	15			.34		O/S TRIPOD LINK LUG 'E'	1.137	.058	.445	
0010	E				RML-SU-T1			.50	SET UP TOBIN ARP BORING MACHPRORATE OVER 'E' & 'F' LUG		.80267		.461	
0020	E				RML-HP-AA			1.00	HAND HANDLE MORAP SIMPL FXTR		.05454		.062	
0030	E				RML-AL-AC			1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0040	E				RML-BC-BK			1.00	BORE HOLE 1.5 X 5 GROUP 3		.59555		.684	
0050	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0120			JA	01	15			.29		O/S TRIPOD LINK LUG 'F'	.936	.041	.312	
0010	E				RML-SU-T1			.50	SET UP TOBIN ARP BORING MACHPRORATE OVER 'E' & 'F' LUG		.80267		.461	
0020	E				RML-HP-AA			1.00	HAND HANDLE MORAP SIMPL FXTR		.05454		.062	
0030	E				RML-AL-AC			1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0040	E				RML-BC-BE			1.00	BORE HOLE 1.5 X 2.5 GROUP 3		.39449		.453	
0050	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
			JA	01	15			.96		MACH BUSH LUG 'E'	.766	.110	.847	
0010	E				RLA-SU-S3			.50	SET UP SMALL MEDIUM LATHE	PRORATE OVER 'E' & F' LUGS	.49962		.287	
0013									19 FEB 87 NEW OCC FACTORS & REVIEW OLD STD	2.74				
0020	E				RLA-HP-C5			2.00	PUT PART IN & OUT OF COLLET	2 BUSHINGS	.00642		.014	
0030	E				KML-TD-DA			2.00	DIA 1.00-1.50 REMOVE (.033	2 BUSHINGS	.09677		.222	
0035	E				RLA-FR-CG			2.00	FACE ROUGH 1 - 1.5 DIA GRP 42	BUSHINGS	.01810		.041	
0040	E				RLA-FF-CG			2.00	FACE FINISH 1- 1.5 GROUP 4	2 BUSHINGS	.03679		.084	
0050	E				RLG-RS-B1			2.00	BRUSH PLATE SPOT OR HOLE	BRUSH PLATE BUSHINGS	.09546		.219	
0110	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0219			JA	01	15			.96		INSTALL BUSH LUG 'E'	.126	.018	.139	
0060	E				RBW-BU-S1			.50	SET UP TO REBUSH BOSSES	PRORATE OVER 'E' & 'F' LUGS	.18669		.107	
0070	E				RBW-BU-A2			1.00	INSTALL SET STRAIGHT BUSHING		.02299		.026	
0110	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0220			JA	01	15			.96		FINISH LINE BORE OR HONE ID	.182	.026	.201	
0080	E				ZHO-SU-S2			.50	SETUP SUNNEN HONE STROKER	PRORATE OVER 'E' & 'F' LUGS	.21517		.123	
0090	N				ZHO-SU-S3			1.00	HONE SMALL PART-SUNNEN HONE		.06450		.074	
0110	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0238			JA	01	15			1.00		MACH BUSH LUG 'F'	.764	.115	.882	
0010	E				RLA-SU-S3			.50	SET UP SMALL MEDIUM LATHE	PRORATE OVER 'E' & 'F' LUGS	.49962		.287	
0020	E				RLA-HP-C5			2.00	PUT PART IN & OUT OF COLLET	2 BUSHINGS	.00642		.014	
0030	E				KML-TD-DA			2.00	DIA 1.00-1.50 REMOVE (.033		.09677		.222	
0035	E				RLA-FR-CG			2.00	FACE ROUGH 1 - 1.5 DIA GRP 4		.01810		.041	
0040	E				RLA-FF-CG			2.00	FACE FINISH 1- 1.5 GROUP 4		.03679		.084	
0050	E				RLG-RS-B1			2.00	BRUSH PLATE SPOT OR HOLE	BRUSH PLATE 2 BUSHINGS	.09546		.219	
0100	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
			JA	01	15			1.00		INSTALL BUSH LUG 'F'	.126	.019	.145	
.0	E				RBW-BU-S1			.50	SET UP TO REBUSH BOSSES	PRORATE OVER 'E' & 'F' LUGS	.18669		.107	
0070	E				RBW-BU-A2			1.00	INSTALL SET STRAIGHT BUSHING		.02299		.026	

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    00 E          RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                          .01001          .011
       JA 01      15         1.00                          FINISH LINE BORE OR HONE ID  .182   .027    .209
    0080 E        ZHO-SU-S2   .50 SETUP SUNNEN HONE STROKER  PRORATE OVER 'E' & 'F' LUGS .21517          .123
    0090 M        ZHO-SU-S3  1.00 HONE SMALL PART-SUNNEN HONE                           .06450          .074
    0100 E        RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                          .01001          .011
  9000      JA 01  15          .01                          LABOR STANDARD HISTORY     .000   .000    .000
    0005                          PRIOR HISTORY ON OO-ALC 494 FORM
    0010                          24FEB83 NEW OCC. FACTOR STUDY                2.08
    0011                          31JUL84 REWRITE STD W/NEW OCC FACTORS<OLD STD>2.34
    0012                          23JUL85 NEW OCC FACTORS & REVIEW  <OLD STD>  2.43
    0013                          23 FEB 87 NEW OCC FACTORS & REVIEW OLD STD   2.74
    0900                          MANEL MRP II CLINTON BENTLEY 7-3255


TO INTERROGATE LABOR STANDARDS, INPUT

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UPER SUB STEP	TECH T D	S K L	S W R K	F A C	PF FA DC	A/R SUPPORT ELEMENT	REV OCC FACT	DESCRIPTION <---------- STORED	DESCRIPTION ----------> SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY
A008	S	E	JA	EA	1	J 88231	1.00	PERCENT ENGR 99.6	MACH STEERING PLATES	6.50		6.50	
0001			JA	01	00		.00		PART NUMBER/NSN	.000	.000	.000	
0010								5-68457-5	1620006052768				
0120			JA	01	15		.14		DRILL BOTTOM PLATE	1.206	.025	.194	
0010	E				RML-SU-V2		.25	S/U VERT MILL BORE LRG FIXTR	PRORATE OVER 4 PARTS	.80167		.230	
0020	E				RML-HP-CC		1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
0030	E				RML-AL-AB		2.00	ALIGN VERTICAL AXIS ROD		.12699		.292	
0040	E				RML-AL-AC		2.00	ALIGN HOLE TO SPINDLE ROD		.07609		.175	
0050	E				RML-BA-CD		2.00	BORE HOLE 2 X 2 GROUP 1	USE PROPER ELEMENT/TABLE	.21626		.497	
0060	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0140			JA	01	15		.27		O/S MOUNTING BOLT HOLES	1.059	.043	.329	
0010	E				RDR-SU-R1		.25	S/U TO O/S BOSSES RAD DRILL	PRORATE OVER 4 PARTS	.56378		.162	
0020	E				RDR-BO-A1		1.00	O/S BOSS W/STEP RMR RAD DRL		.30463		.350	
0030	E				RDR-BO-A2		4.00	O/S ADML BOSS STP RMR RAD DR	OCCURANCE = 4 HOLES	.14687		.675	
0040	E				RBW-DB-A1		4.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.019	
0050	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0160			JA	01	15		.27		O/S TORQUE ARM HOLES	.757	.031	.235	
0010	E				RDR-SU-R1		.25	S/U TO O/S BOSSES RAD DRILL	PRORATE OVER 4 PARTS	.56378		.162	
0020	E				RDR-BO-A1		1.00	O/S BOSS W/STEP RMR RAD DRL		.30463		.350	
0030	E				RDR-BO-A2		2.00	O/S ADML BOSS STP RMR RAD DR	OCCURRANCE = 2 HOLES	.14687		.337	
0040	E				RBW-DB-A1		2.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.009	
0050	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0180			JA	01	15		.20		NICK & BURR	.459	.014	.106	
0010	E				RBW-SU-G1		1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
0020	E				RLG-RS-N3		1.00	NICK & BURR MED STRUT PART		.13711		.077	
0030	E				GTL-EP-A2		1.00	SET UP & DISMANTLE AIR DRILL		.06078		.007	
0040	N						1.00		REMOVE DEEP PITTING	.10000		.115	
0050	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0398			JA	01	15		1.00		MACH MOUNTING BOLT BUSH	.876	.131	1.008	
0010	E				RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020	E				RLA-HP-C5		12.00	PUT PART IN & OUT OF COLLET	...	.00642		.088	
0030	E				KML-TA-DA		12.00	DIA 1.00-1.50 REMOVE (.033	DIA 1.00-1.50 REM .033-.250	.05535		.763	
0040	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0400			JA	01	15		1.00		INST MOUNTING BOLT BUSH	.221	.033	.255	
0010	E				RBW-BU-S1		.50	SET UP TO REBUSH BOSSES		.18669		.107	
0020	E				RBW-BU-A4		1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030	E				RBW-BU-A3		11.00	INST ADML STRAIGHT BUSHING		.00886		.112	
0040	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0405			JA	01	15		1.00		FINISH MOUNTING BOLT BUSH	2.268	.340	2.609	
0010	E				RDR-SU-R1		.25	S/U TO O/S BOSSES RAD DRILL	PRORATE OVER 4 PARTS	.56378		.162	
0020	E				RDR-BO-A1		1.00	O/S BOSS W/STEP RMR RAD DRL		.30463		.350	
0030	E				RDR-BO-A2		12.00	O/S ADML BOSS STP RMR RAD DR	12 BUSHINGS	.14687		2.026	
0040	E				RBW-DB-A1		12.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.058	
0050	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0418			JA	01	15		.94		MACH TORQUE ARM BUSH	.428	.060	.463	
0010	E				RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020	E				RLA-HP-C5		4.00	PUT PART IN & OUT OF COLLET		.00642		.029	
0030	E				KML-TA-EC		4.00	DIA 1.50-2.00 REM .033-.250	4 BUSHINGS	.06699		.308	
0040	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	

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      JA 01  15          .94                          INST TORQUE ARM BUSH          .148   .021    .161
 0110 E      RBW-BU-S1   .25 SET UP TO REBUSH BOSSES   PRORATE OVER 4 PARTS          .18669         .053
 0120 E      RBW-BU-A2  4.00 INSTALL SET STRAIGHT BUSHING NO POLISH                  .02299         .105
 0030 E      RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                            .01001         .011
 0425   JA 01  15          .94                          FINISH TORQUE ARM BUSH       1.059   .149   1.146
 0010 E      RDR-SU-R1   .25 S/U TO O/S BOSSES RAD DRILL PRORATE OVER 4 PARTS       .56378         .162
 0020 E      RDR-BO-A1  1.00 O/S BOSS W/STEP RMR RAD DRL                           .30463         .350
 0030 E      RDR-BO-A2  4.00 O/S ADML BOSS STP RMR RAD DR  4 BUSHINGS              .14687         .675
 0040 E      RBW-DB-A1  4.00 DEBUR HOLE/CUTOUT BOTH SIDES                          .00423         .019
 0050 E      RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                          .01001         .011
 9000   JA 01  15          .01                          LABOR STANDARD HISTORY       .000   .000    .000
 0010                        PRIOR HISTORY ON OO-ALC 494 FORM
 0020                        24FEB83 NEW OCC. FACTOR STUDY                 8.67
 0030                        25MAY83 ADD RJPPWR1 ELEMENT TO SUB OP 0020 & 0030
 0040                        25MAY83                                TIME WAS 7.21
 0041                        31JUL84 REWRITE STD W/NEW OCC FACTORS<OLD STD>7.21
 0042                        23JUL85 NEW OCC FACTORS & REVIEW <OLD STD>   5.85
 0043                        19 FEB 87 NEW OCC FACTORS & REVIEW OLD STD    8.01
 0900                        CLINTON BENTLEY TECH MANEL 3357
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TO INTERROGATE LABOR STANDARDS, INPUT

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OPER SUB STEP	TECH T	S K D	S L	W #R K	F A C	PF FA DC	A/R SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY
RA009	S	E	JA	EA	1	J	85204	.08	PERCENT ENGR 94.2	REP TORQUE ARM 2EA.B52M 507	1.27		.10	
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000	
0010									1-80721-1	1620003170530				
0178			JA	01	15			1.00		REP ARM	.643	.097	.740	
0035	E					RLA	SU-S3	.50	SET UP SMALL MEDIUM LATHE	PRORATE 2 PARTS	.49962		.287	
0040	E					RLA	HP-C5	1.00	PUT PART IN & OUT OF COLLET		.00642		.007	
0050	E					KML	TD-DA	1.00	DIA 1.00-1.50 REMOVE (.033		.09677		.111	
0060	E					KML	TD-DB	1.00	DIA 1.50 REM .033 ADD INCH		.03661		.042	
0070	E					RLA	BO-C6	1.00	BORE HOLE 1 - 1 1/2 DIA 1 DP		.17094		.196	
0080	E					RLA	BO-CH	1.00	BORE HOLE 1-1.5 DIA. ADD IN		.07326		.084	
0150	E					RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0180			JA	01	15			1.00		REP ARM	.469	.070	.539	
0010	E					RBW	SU-G1	.50	S/U FOR BENCH WORK GENERAL	PRORATE 2 PARTS	.27525		.158	
0020	E					RSG	JP-03	.50	PREP HAND DRILL FOR USE	PRORATE 2 PARTS	.00861		.004	
0030	M					ZHO	SU-S3	1.00	HONE SMALL PART-SUNNEN HONE	HONE LUG TO SIZE	.06450		.074	
0090	E					RBW	BU-S1	.50	SET UP TO REBUSH BOSSES	PRORATE 2 PARTS	.18669		.107	
0100	E					KPA	AC-A1	3.75	PAINT-AEROSOL-PER SQ INCH	L X D 2.5 X 1.5	.00007		.000	
0110	E					RBW	BU-B2	.50	REBUSH A SET OF 2 BOSSES	1 BUSHING	.22231		.127	
0120	E					GTL	EP-A2	.50	SET UP & DISMANTLE AIR DRILL	PRORATE 2 PARTS	.00678		.003	
0130	E					RLA	DR-DB	1.00	DRILL HOLE 1/4-1/2 DIA X 1	DRILL GREASE HOLE	.04300		.049	
10	E					RBW	DB-B1	1.00	DEBURR HOLE BURRQUICK TOOL		.00142		.001	
.150	E					RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000			JA	01	15			.01		LABOR STANDARD HISTORY	.000	.000	.000	
0010									PRIOR HISTORY ON OO-ALC 494 FORM					
0020									24FEB83 NEW OCC. FACTOR STUDY 2.73					
0021									31JUL84 REWRITE STD W/NEW OCC FACTORS<OLD STD>2.59					
0022									23JUL85 NEW OCC FACTORS & REVIEW <OLD STD> .17					
0900									MANEL MRP II CLINTON BENTLEY 7-3255					

TO INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 09/06/88 A-E046B-MM1-DY-M45 PAG

17143A STRUT B-52 MLG RCC MNPRA 4S1-57-3

OPER SUB STEP	TECH D	S S T K L	W F PF A R REV K C DC	A/R SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DL
RA010	E	N	JA EA 1	J 88232	1.00	PERCENT ENGR .0	CENTERING CAM B52M	.44		.44	
0001			JA 01	00	1.00		PART NUMBER/NSN	.000	.000	.000	
0010						25-4214-501	1620007330993				
0100			JA 01	00	.96		CAM KEY REPAIR	.333	.000	.320	
0010	N				1.00		45 DEGREE CHAMFER	.33300		.333	
0105			JA 01	00	.10		CAM KEY REPAIR	.333	.000	.033	
0010	N				1.00		RADIUS ON KEYS	.33300		.333	
0110			JA 01	15	1.00		ETCH MARKS & RENUMBER	.083	.012	.095	
0010	N				1.00		ELECTRO ETCH & RENUMBER	.08300		.095	
9000			JA 01	15	.05		LABOR STANDARD HISTORY	.000	.000	.000	
0001						31JUL84 REWRITE STD W/NEW OCC FACTORS<OLD STD> .15					
0010						PRIOR HISTORY ON OO-ALC 494 FORM					
0020						24FEB83 NEW OCC FACTOR STUDY UPDATE .15					
0021						10DEC84 ADD SUB OP 0110&0125 OCC EST.<OLD STD>.09					
0022						23JUL85 NEW OCC FACTORS & REVIEW <OLD STD> .10					
0023						04FEB86 DELETE SUB OP 0120,0125 <OLD STD> .15					
0024						19 FEB 87 NEW OCC FACTORS & REVIEW OLD STD .15					
0900						CLINTON BENTLEY TECH MANEL 3357					

TO INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 09/06/88 A-E046B-MM1-DY-M45 PAGE

17143A STRUT B-52 MLG RCC MNPRA 4S1-57-3

OPER SUB STEP	TECH D	S T L	S K K	W #R	F A C	PF FA DC	A/R SUPPORT ELEMENT	REV OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DL
RA014	S	E	JA	EA	1	J	88244	.13	PERCENT ENGR 99.9	PISTON HEAD NUT B52 MLG	3.78		.49	
0001			JA	01		00		.00		PART NUMBER/NSN	.000	.000	.000	
0010									3-80736-3	5310006035970LE				
0023			JA	01		15		1.00		REPAIR KEYWAY SLOT	3.294	.494	3.789	
0010	E						RML-SU-V1	.20	S/U VERT MILL BORE SMAL FXTR	PRORATED 5 EA PARTS AT TIME	.75732		.174	
0020	E						RML-AL-BA	6.00	ALIGN HORIZ AXIS CLAMP	6 EA SLOTS	.05541		.382	
0030	E						RML-AL-BB	6.00	ALIGN VERTICAL AXIS CLAMP	6 EA SLOTS	.11975		.826	
0035	E						RML-AL-AC	6.00	ALIGN HOLE TO SPINDLE ROD	6 EA SLOTS	.07609		.525	
0040	E						RML-BD-AA	6.00	BORE HOLE 1 X 1/2 GROUP 4	6 EA SLOTS	.27100		1.869	
0050	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0900									K.HANSEN TECH					
9000			JA	01		15		.01		LABOR STANDARD HISTORY	.000	.000	.000	
0010									PRIOR HISTORY ON 00-ALC 494 FORM					
0020									24FEB83 NEW OCC. FACTOR STUDY	.18				
0021									31JUL84 NEW OCC FACTOR STUDY <OLD STD>	.25				
0022									23JUL85 NEW OCC FACTOR STUDY & REVIEW <OLD STD.	.51				

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                LABOR STANDARD  OPERATION RESOURCE STANDARD AND METHOD ANALYSIS  09/06/88    A-E046B-MM1-DY-M45  PAGE  0001
'1        STRUT B-52 MLG                              RCC MNPRA                 4S1-57-3
  S S   W F PF A/R REV
  T K   #R A FA SUPPORT   OCC <---------------------- DESCRIPTION ---------------------->  BASE    PFD     STD            A
  D L    K C DC ELEMENT   FACT          STORED                    SUPPLEMENTAL           HOURS   TIME    HOURS    DLY PCT C
-------------------------------------------------------------------------------------------------------------------------------
  E JA EA 1    J 85260   .10 PERCENT ENGR 99.9          REP STOP ASSEMBLY,JACKSHAFT      .45             .04
    JA 01   00           .00                           PART NUMBER/NSN                  .000   .000     .000       0
)                           4-80884              1620003079347
    JA 01   15          1.00                           DRILL 4 EA HOLES                 .391   .059     .451     100
) E          RDR-SU-V1   .50 S-U DR PRS W-VISE FIXT DV-HDPRORATE 2 PARTS                .42803           .246
) E          KNL-CD-P1  4.00 CENTER DRILL               CENTER DRILL 4 HOLES           .01519           .069
) E          GAE-TL-01  4.00 DRILL W/DRILL PRESS TO 1/4  DRILL 4 HOLES                 .02228           .102
) E          KTL-DB-A1  4.00 DEBURR HOLE FIRST BOTH SIDES4 HOLES                       .00449           .020
0 E          RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                              .01001           .011
    JA 01   15           .01                           LABOR STANDARD HISTORY           .000   .000     .000       0
)                           12SEP85 NEW OPERATION-NO HISTORY
0                           MANEL MRP II CLINTON BENTLEY  7-3255


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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 09/06/88 A-E046B-MM1-DY-M45 PAGE

47143A STRUT B-52 MLG RCC MNPRB 4S1-57-3

OPER SUB STEP	TECH T D	S K L	W #R K	F A C	PF FA DC	A/R SUPPORT ELEMENT	REV OCC FACT	<---------- DESCRIPTION ----------> STORED	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY
MNPRB	E	X	JA	EA	3	K 87278	1.00	PERCENT ENGR .0	RECYCLE TIME	2.15		2.15	
0010			JA	01	00		1.00		REWORK TIME	2.150	.000	2.150	
0010	N						1.00		RECYCLE	2.15000		2.150	
0020								REWORK TIME IDENTIFIED BY RCC FOREMAN					
9000			JA	00	00		.00		LABOR STANDARD HISTORY	.000	.000	.000	
0001								5 OCT 87 INITIAL INPUT					

TO INTERROGATE LABOR STANDARDS, INPUT

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17143A STRUT B-52 MLG RCC MNPRB 4S1-57-3

OPER SUB STEP	TECH D	S T L	S K	W #R K	F A C	PF FA DC	A/R SUPPORT ELEMENT	REV OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY
RB001	S	N	JA	EA	3	J	85204	.08	PERCENT ENGR 55.3	REP OUTER CYL B52 MLG 507	3.47		.27	
0001			JA	01		00		.00		PART NUMBER/NSN	.000	.000	.000	
0010									7027516-10	162000241544				
0525			JA	01		15		1.00		HONE CYL I.D.	3.022	.453	3.476	
0010	E						RHO-SU-V2	1.00	SET UP VERY LARGE HONE		.79152		1.140	
0020	E						RHO-HM-F1	1.00	ADJUST HONING FIXTURE		.17589		.202	
0030	E						RHO-HP-L1	1.00	LOAD UNLOAD HONE WITH HOIST		.17802		.204	
0040	E						RHO-HM-H3	1.00	CHANGE STONES ON VERY LARGE		.19652		.225	
0050	E						RHO-HM-S1	1.00	ADJUST STOPS LARGE VERT HONE		.01422		.016	
0060	N							1.00		HONE I.D.	1.35000		1.552	
0070	E						RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24		.10674		.122	
0080	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000			JA	01		15		.01		LABOR STANDARD HISTORY	.000	.000	.000	
0010									01MAR84 NEW OPERATION - NO HISTORY					
0011									31JUL84 NEW OCC FACTOR <OLD STD>					
0012									23JUL85 NEW OCC FACTORS & REVIEW <OLD STD> .15					
0013									25AUG86-MOVED SUBOP 0515 TO 0525;OLD STD 3.20					
0020									20NOV86 CHANGE FACILITY CODE TO 3/NO TIME CHANGE					
0900									MANEL MRP II CLINTON BENTLEY 7-3255					

TO INTERROGATE LABOR STANDARDS. INPUT

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OPER SUB STEP	TECH T D	S S K L	W #R K	F A C	PF FA DC	A/R REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY
RB002	S	E	JA	EA	3	J 85204	.46	PERCENT ENGR 99.9	GRIND INNER CYL B52 MLG 507	18.88		8.68	
0010			JA 01		00		.00		PART NUMBER/NSN	.000	.000	.000	
0010						5-85123-6		1620006582588					
9000									LABOR STANDARD HISTORY				
0375			JA 01		15		.37		1ST GRIND INNER O.D.	8.656	.480	3.684	
0010	E			RGR-SU-G1	1.00	SET UP A GAP GRINDER				1.05938		1.218	
0020	E			RGR-HP-L1	1.00	LOAD LARGE PART GAP GRINDER				.13653		.157	
0030	E			RML-SU-A1	1.00	DIAL ONE AXIS LONG OR CROSS				.04777		.054	
0040	E			KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION				.06761		.077	
0050	E			KMG-OD-RE	7.00	GRIND .010 9DIA X 3 LONG		21.75 X 8.5 O.D.		.76185		6.132	
0060	E			RGR-GE-D2	9.00	DWELL (GAP GRINDER STEEL OD)		8 TO 9 INCH DIA		.01014		.104	
0070	E			RGR-WD-G2	2.00	WHEEL DRESS GAP GRINDER		ALLOW 2 WHEEL DRESSES		.08334		.191	
0080	E			RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24				.10674		.122	
0090	E			RGR-SU-A1	1.00	SET UP INTERNAL ATT GAP GRND				.78266		.900	
0100	E			KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION				.06761		.077	
0110	E			KMG-OD-RC	1.00	GRIND .010 9DIA X 2 LONG		GRIND FLANGE AREA 2 X 8.5 OD		.52384		.602	
0120	E			RGR-WD-G2	2.00	WHEEL DRESS GAP GRINDER		ALLOW 2 WHEEL DRESSES		.08334		.191	
0130	E			RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12				.09717		.111	
0140	E			RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC				.01001		.011	
			JA 01		15		.28		1ST GRIND AXLE JOURNAL #1	1.295	.054	.417	
010	E			RGR-SU-G1	.25	SET UP A GAP GRINDER			PRORATE O/P420,440,460 & 480	1.05938		.304	
0020	E			RGR-HP-L1	.50	LOAD LARGE PART GAP GRINDER			PRORATE O/P420,460	.13653		.078	
0030	E			KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION				.06761		.077	
0040	E			KMG-OD-LC	2.00	GRIND .010 5 OD X 2		L 4 X 4.98 O.D.		.29334		.674	
0050	E			RGR-GE-D2	5.00	DWELL (GAP GRINDER STEEL OD)		5 IN O.D.		.01014		.058	
0060	E			RGR-WD-G2	2.00	WHEEL DRESS GAP GRINDER		ALLOW 2 WHEEL DRESSES		.08334		.191	
0070	E			RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5				.08102		.093	
0080	E			RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC				.01001		.011	
0405			JA 01		15		.37		1ST GRIND AXLE JOURNAL #2	1.298	.072	.552	
0010	E			RGR-SU-G1	.25	SET UP A GAP GRINDER			PRORATE O/P420,440,460 & 480	1.05938		.304	
0020	E			GOH-MH-01	.50	TURN OBJECT OVER USING HOIST			PRORATE 2 JOURNALS TO SIDE	.00445		.002	
0030	E			RGR-HP-L1	.50	LOAD LARGE PART GAP GRINDER			PRORATE O/P 440 & 480	.13653		.078	
0040	E			KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION				.06761		.077	
0050	E			KMG-OD-LC	2.00	GRIND .010 5 OD X 2		L 4 X 4.98 O.D.		.29334		.674	
0060	E			RGR-GE-D2	5.00	DWELL (GAP GRINDER STEEL OD)		5 IN O.D.		.01014		.058	
070								24.0X8.0					
080	E			RGR-WD-G2	2.00	WHEEL DRESS GAP GRINDER		ALLOW 2 WHEEL DRESSES		.08334		.191	
0090	E			RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5				.08102		.093	
0100	E			RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC				.01001		.011	
0420			JA 01		15		.37		1ST GRIND AXLE JOURNAL #3	1.429	.079	.608	
0010	E			RGR-SU-G1	.25	SET UP A GAP GRINDER			PRORATE O/P420,440,460 & 480	1.05938		.304	
0020	E			RGR-HP-L1	.50	LOAD LARGE PART GAP GRINDER			PRORATE O/P 460 & 420	.13653		.078	

		RGR-GE-D2	5.00	DWELL (GAP GRINDER STEEL OD)5 IN O.D.			.01014		
		RGR-WD-G2	2.00	WHEEL DRESS GAP GRINDER	ALLOW 2 WHEEL DRESSES		.08334		.191
	E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5			.08102		.093
0080	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011
0435	JA 01	15	.46		1ST GRIND AXLE JOURNAL #4		1.429	.099	.756
0010	E	RGR-SU-G1	.25	SET UP A GAP GRINDER	PRORATE O/P420.440.460 & 480		1.05938		.304
0020	E	RGR-HP-L1	.50	LOAD LARGE PART GAP GRINDER	PRORATE O/P 480 & 440		.13653		.078
0030	E	KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION			.06761		.077
0040	E	KMG-OD-LD	2.00	GRIND .010 FROM 5 IN OD X2.5L5 IN X 5.23 O.D.			.36000		.828
0050	E	RGR-GE-D2	5.00	DWELL (GAP GRINDER STEEL OD)5 IN O.D.			.01014		.058
0060	E	RGR-WD-G2	2.00	WHEEL DRESS GAP GRINDER	ALLOW 2 WHEEL DRESSES		.08334		.191
0070	E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5			.08102		.093
0080	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011
0450	JA 01	15	.91		INNER CYL BORE SEAL AREA		1.973	.269	2.065
0010	E	RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL			.27525		.316
0020	E	RSG-JP-03	1.00	PREP HAND DRILL FOR USE			.00861		.009
0030	E	ZPO-BP-C1	1.00	BUTTERFLY POLISH SM CYL I.D.			.06549		.075
0040	E	RGR-SU-P1	.80	SET UP PLANETARY GRINDER	GROUND APROX 80% THE TIME		.82175		.756
0050	E	RML-SU-F3	.80	LRG FIXTUR TO/FRM MACH HOIST	GROUND APROX 80% THE TIME		.45621		.419
0060	E	RML-HP-H3	.80	PART ON/OFF MACH HOIST NORAP	GROUND APROX 80% OF THE TIME		.10313		.094
0070	E	RML-AL-CC	.80	ALIGN HOLE TO SPINDLE MAG BS	GROUND APROX 80% OF THE TIME		.07261		.066
0080	E	KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION			.06761		.077
0090	E	KMG-ID-QB	.80	GRIND OUT .010 8.00 ID X 1	GROUND APROX 80% OF THE TIME		.37365		.343
0100	E	KMG-DW-ID	.80	DRESS INTERNAL WHEEL	GROUND APROX 80% OF THE TIME		.02458		.022
0110	E	RGR-HM-C2	.80	HANDLE & MEAS LENGTH 1 TO 5	GROUND APROX 80% OF THE TIME		.08102		.074
0120	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011
0465	JA 01	15	.28		1ST GRIND SEAL AREA		1.320	.055	.425
0010	E	RGR-SU-P1	.50	SET UP PLANETARY GRINDER	PRORATE O/P 390 & 410		.82175		.472
0020	E	RML-SU-F3	.50	LRG FIXTUR TO/FRM MACH HOIST	PRORATE O/P 390 & 410		.45621		.262
0030	E	RML-HP-H3	.50	PART ON/OFF MACH HOIST NORAP	PRORATE O/P 390 & 410		.10313		.059
0040	E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS			.07261		.083
0050	E	KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION			.06761		.077
0060	E	KMG-ID-QB	1.00	GRIND OUT .010 8.00 ID X 1	1 X 8 I.D.		.37365		.429
0070	E	KMG-DW-ID	1.00	DRESS INTERNAL WHEEL			.02458		.028
0080	E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5			.08102		.093
0090	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011
0495	JA 01	15	.10		1ST GRIND INNER I.D.		8.569	.129	.985
0010	E	RGR-SU-P1	.50	SET UP PLANETARY GRINDER	PRORATE O/P 390 & 410		.82175		.472
0020	E	RML-SU-F3	.50	LRG FIXTUR TO/FRM MACH HOIST	PRORATE O/P 390 & 410		.45621		.262
0030	E	RML-HP-H3	.50	PART ON/OFF MACH HOIST NORAP	PRORATE O/P 390 & 410		.10313		.059
0040	E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS			.07261		.083
0050	E	KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION			.06761		.077
0060	E	KMG-ID-QD	11.00	GRIND OUT .010 8.0 ID X 2.0 L 22 IN X 7.9 O.D.			.67681		8.561
0070	E	RGR-WD-G2	2.00	WHEEL DRESS GAP GRINDER	ALLOW 2 WHEEL DRESSES		.08334		.191
0080	E	RGR-HM-C5	1.00	HANDLE & MEAS LENGTH 24 - 36			.11700		.134
0090	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011
0790	JA 01	15	.37		FINISH GRIND INNER O.D.		12.728	.706	5.416
0010	E	RGR-SU-G1	1.00	SET UP A GAP GRINDER			1.05938		1.218
0020	E	RGR-HP-L1	1.00	LOAD LARGE PART GAP GRINDER			.13653		.157
0030	E	RML-SU-A1	1.00	DIAL ONE AXIS LONG OR CROSS			.04777		.054
0040	E	KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION			.06761		.077
0050	E	KMG-OD-RK	7.00	GRIND .040 9DIA X 3 LONG	21.75 X 8.5 O.D.		1.22619		9.870
0060	E	RGR-GE-D3	9.00	DWELL (GAP GRINDER CHROM OD)8 TO 9 INCH DIA.			.02029		.210
0070	E	RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24			.10674		.122

		KMG-OD-RH	1.00 GRIND .040 9DIA X 2 LONG	GRIND FLANGE AREA 2 X 8.5 OD	.94502		.971
		RGR-WD-G2	3.00 WHEEL DRESS GAP GRINDER	3 WHEEL DRESSES	.08334		.287
	E	RGR-GE-D3	9.00 DWELL (GAP GRINDER CHROM OD)8 TO 9 INCH DIA		.02029		.210
0130	E	RGR-HM-C4	1.00 HANDLE & MEAS LENGTH 12 - 24		.10674		.122
0140	E	GTL-EP-A2	1.00 SET UP & DISMANTLE AIR DRILL		.00678		.007
0150	E	RLG-RS-P4	2.00 POLISH PLATED SURF INNER CYL2 AREAS		.14667		.337
50	E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
	JA 01	15	.28	FINISH GRIND AXLE JOURNAL #1	1.587	.067	.511
0010	E	RGR-SU-G1	.25 SET UP A GAP GRINDER	PRORATE O/P840,850,860 & 870	1.05938		.304
0020	E	RGR-HP-L1	.50 LOAD LARGE PART GAP GRINDER	PRORATE O/P 840 & 860	.13653		.078
0030	E	RML-SU-A1	1.00 DIAL ONE AXIS LONG OR CROSS		.04777		.054
0040	E	KMG-GW-LK	1.00 LOCATE WHEEL TO POSITION		.06761		.077
0050	E	KMG-OD-LH	2.00 GRIND .040 FROM 5 IN OD X 2 L4 X5 IN O.D.		.47334		1.088
0060	E	RGR-GE-D3	5.00 DWELL (GAP GRINDER CHROM OD)5 INCH DIA		.02029		.116
0070	E	RGR-HM-C2	1.00 HANDLE & MEAS LENGTH 1 TO 5		.08102		.093
0080	E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0810	JA 01	15	.37	FINISH GRIND AXLE JOURNAL #2	1.587	.088	.676
0010	E	RGR-SU-G1	.25 SET UP A GAP GRINDER	PRORATE O/P840,850,860 & 870	1.05938		.304
0020	E	RGR-HP-L1	.50 LOAD LARGE PART GAP GRINDER	PRORATE O/P 850 & 870	.13653		.078
0030	E	RML-SU-A1	1.00 DIAL ONE AXIS LONG OR CROSS		.04777		.054
0040	E	KMG-GW-LK	1.00 LOCATE WHEEL TO POSITION		.06761		.077
0050	E	KMG-OD-LH	2.00 GRIND .040 FROM 5 IN OD X 2 L4 X 5 IN O.D.		.47334		1.088
0060	E	RGR-GE-D3	5.00 DWELL (GAP GRINDER CHROM OD)5 IN DIA		.02029		.116
0070	E	RGR-HM-C2	1.00 HANDLE & MEAS LENGTH 1 TO 5		.08102		.093
0080	E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0820	JA 01	15	.37	FINISH GRIND AXLE JOURNAL #3	2.094	.116	.891
0010	E	RGR-SU-G1	.25 SET UP A GAP GRINDER	PRORATE O/P840,850,860 & 870	1.05938		.304
0020	E	RGR-HP-L1	.50 LOAD LARGE PART GAP GRINDER	PRORATE O/P 840 & 860	.13653		.078
0030	E	RML-SU-A1	1.00 DIAL ONE AXIS LONG OR CROSS		.04777		.054
0040	E	KMG-GW-LK	1.00 LOCATE WHEEL TO POSITION		.06761		.077
0050	E	KMG-OD-LJ	2.00 GRIND .040 FROM 5 OD X 2 1/25 IN X 5.23 O.D.		.58001		1.334
0060	E	RGR-GE-D3	5.00 DWELL (GAP GRINDER CHROM OD)5 INCH DIA		.02029		.116
70	E	RGR-HM-C2	1.00 HANDLE & MEAS LENGTH 1 TO 5		.08102		.093
80	E	RLG-RS-P4	2.00 POLISH PLATED SURF INNER CYLAXLE JOURNALS 1 & 3		.14667		.337
0090	E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0830	JA 01	15	.46	FINISH GRIND AXLE JOURNAL #4	2.094	.145	1.108
0010	E	RGR-SU-G1	.25 SET UP A GAP GRINDER	PRORATE O/P840,850,860 & 870	1.05938		.304
0020	E	RGR-HP-L1	.50 LOAD LARGE PART GAP GRINDER	PRORATE O/P 870 & 850	.13653		.078
0030	E	RML-SU-A1	1.00 DIAL ONE AXIS LONG OR CROSS		.04777		.054
0040	E	KMG-GW-LK	1.00 LOCATE WHEEL TO POSITION		.06761		.077
0050	E	KMG-OD-LJ	2.00 GRIND .040 FROM 5 OD X 2 1/25 IN X 5.23 O.D.		.58001		1.334
0060	E	RGR-GE-D3	5.00 DWELL (GAP GRINDER CHROM OD)5 IN DIA		.02029		.116
0070	E	RGR-HM-C2	1.00 HANDLE & MEAS LENGTH 1 TO 5		.08102		.093
0080	E	RLG-RS-P4	2.00 POLISH PLATED SURF INNER CYLAXLE JOURNALS 2 & 4		.14667		.337
0090	E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001		.011
0100			K.HANSEN TECH.				
0840	JA 01	15	.28	FINISH GRIND I.D. SEAL AREA	2.453	.103	.790
10	E	RGR-SU-P1	1.00 SET UP PLANETARY GRINDER		.82175		.945
0	E	RML-SU-F3	1.00 LRG FIXTUR TO/FRM MACH HOIST		.45621		.524
030	E	RML-HP-H3	1.00 PART ON/OFF MACH HOIST MORAP		.10313		.118
0040	E	RML-AL-CC	1.00 ALIGN MDLE TO SPINDLE MAG BS		.07261		.083
0050	E	KMG-GW-LK	1.00 LOCATE WHEEL TO POSITION		.06761		.077
0060	E	KMG-ID-QG	1.00 GRIND OUT .040 8 ID X 1	1 X 8 I.D.	.76764		.882
0070	E	KMG-DW-ID	3.00 DRESS INTERNAL WHEEL	ALLOWED 3 WHEEL DRESSES	.02458		.084

15 .01 LABOR STANDARD HISTORY .000 .000 .000

PRI[illegible]STORY ON OO-ALC 494 FORM
25FE[illegible]3 NEW OCC. FACTOR STUDY UPDATE 11.80
25MAY83 REMOVE ALL RJPPWF1 ELEMENTS <OLD STD> 8.95
01AUG84 REWRITE STD W/NEW OCC FACTORS<OLD STD>8.95
23JUL85 NEW OCC FACTORS & REVIEW <OLD STD> 10.56
19 FEB 87 NEW OCC FACTORS & REVIEW OLD STD 12.93
20NOV86 CHANGE FACILITY CODE FROM 1 TO 3
CLINTON BENTLEY TECH MANEL 3357

0030
0031
0032
0033
0040
0900

TO INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 09/06/88 A-E046B-MM1-DY-M45 PA

17143A STRUT B-52 ML RCC MNPGP 4S1-57-3

OPER SUB STEP	TECH D	S L	S K	W #R	F A	PF FA	A/R DC	REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	D
PM003	S	E	DI	EA	5		J	88229	1.00	PERCENT ENGR 99.9	MATCH UP STRUT B-52M	1.22		1.22	
0001			DI	01		00			.00		PART NUMBER/NSN	.000	.000	.000	
0010										7027648-190	1620001398473				
0020										7027648-210	1620001398474				
0010			DI	01		21			1.00		MATCH UP	1.010	.212	1.223	
0110	E					RLG-MU-01			1.00	MATCH UP PARTS FOR ASSEMBLY		.52681		.637	
0120	E					GCE-JP-TO			1.00	T.O. RESEARCH		.19359		.234	
0130	E					RJP-PW-R1			28.00	REM RPL PAPRWRK SIGN OFF DOCOCC FOR 14 EA 958		.01001		.339	
0140	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
9000			DI	01		21			.01		LABOR STANDARD HISTORY	.000	.000	.000	
0010										PRIOR HISTORY ON 00-ALC 494 FORM					
0020										18FEB83 UPDATE OPERATION LINE-2 YEAR REVIEW .93					
0030										08MAR83 ADD SUB OP.0002 FOR PARTS HANDLING OF NOUN					
0040										ROUTED PARTS TIME WAS .93					
0041										01AUG84 2 YEAR REVIEW <OLD STD> 1.35					
0042										24JUL85 2 YEAR REVIEW <OLD STD> 1.36					

TO INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 05/10/89 A-E046B-MM1-DY-M45 PAGE

17143A STRUT B-52 MLG RCC MNPGP 4S1-57-3

SUB STEP	TECH D	S L	S K	W #R	F A	PF C	A/R DC	REV ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY
PS004	S	E	HB	EA	5		J	88230	1.00	PERCENT ENGR 99.9	MOD NEW BEARING B52M	.28		.28	
0001			HB	01		00			.00		PART NUMBER/NSN	.000	.000	.000	
0010										9-52299-505	1620009665426				
0020										9-52532-501	1620009072897				
0140			HB	01		15			1.00		REIDENTIFY / METAL STAMP	.099	.015	.114	
0010		E						RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27525		.079	
0020		E						GID-SA-A1	1.00	STAMP WITH METAL STAMP		.00342		.003	
0030		E						GID-SA-A2	9.00	STAMP W/METAL STAMP ADDL	NINE ADDITIONAL NUMBERS	.00187		.019	
0040		E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0170			HB	01		21			.50		RIVET GEAR TO BEARING	.275	.029	.166	
0010		E						RSG-JP-T1	1.00	JOB PREP GENERAL FOR S & M		.22079		.267	
0020		E						RSG-SD-CA	1.00	DRL)10 HLS IN S/S 3-9 IN SP		.02001		.024	
0030		E						RRV-GN-H1	2.00	INST FIRST RIVET EASY ACCESS	2 EA. RIVETS	.01262		.030	
0040		E						TIT-EA-GH	5.00		2RIVETS 2 SIDES & ALIGNMENT	.00182		.011	
9000			HB	01		00			.00		LABOR STANDARD HISTORY	.000	.000	.000	
0010										17 AUG 88 INITIAL INPUT					
0011										MOVED FROM MNPGP 000100018					

TO INTERROGATE LABOR STANDARDS, INPUT

[redacted]RD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 09/06/88 A-E046B-MM1-DY-M45 PAGE

17143A STRUT B-52 MLG RCC MNPGP 4S1-57-3

OPER SUB STEP	TECH D	S S L	W F PF A/R REV #R A FA SUPPORT K C DC ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY
PS021	E	N HB	EA 5 J 88235	1.00	PERCENT ENGR .0	ASSY STOP JACKSHAFT	.30		.30	
0001		HB	01 00	.00		PART NUMBER/NSN	.000	.000	.000	
0010					4-80884	1620003079347				
0025		HB	01 21	1.00		RIVET STOP ASSY	.250	.053	.303	
0010	N			1.00		RIVET STOP	.25000		.302	
9000		HB	01 00	.00		LABOR STANDARD HISTORY	.000	.000	.000	
0010					22 AUG 88 INITIAL INPUT					
0900					DOLORES HENDRICKS					

TO INTERROGATE LABOR STANDARDS, INPUT

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17143A STRUT B-52 MLG RCC MNPGP 4S1-57-3

OPER STEP	TECH T	S K	S #R	W A	F C	PF DC	A/R SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT
PP017	S	E	HB	EA	5	J	89235	1.00	PERCENT ENGR 99.9	DISSY-ASSY JACKSHAFT B52M	4.28		4.28	
0001			HB	01	00			.00		PART NUMBER/NSN	.000	.000	.000	0
0010									5-68470-2	1620003079442				
0006			HB	01	21			1.00		HAND CLEAN	1.646	.346	1.993	47
0010	E				RLG-CS-T1			1.00	CL BSKT STRUT PTS IN TRICAL		.08559		.103	
0020	E				RLG-RS-N4			1.00	NICK & BURR SMALL STRUT PART/		.04595		.055	
0025	E				GCE-ME-A1			1.00		MOVE PARTS TO BLAST	.17191		.208	
0030	E				RLG-EI-C6			3.00	CHK ALL WARE AREAS BY MESRNG/3 EACH PARTS		.44779		1.625	
0007			HB	01	21			1.00		DISASSEMBLE JACKSHAFT	.582	.122	.705	16
0005	E				GCE-JP-T0			1.00	T.O. RESEARCH		.19359		.234	
0010	E				GLM-FB-DA			8.00	REMOVE BOLT,WASHER AND NUT	/REMOVE 8 EA BOLTS	.01059		.102	
0020	E				ANF-CP-D1			5.00	REMOVE COTTERPIN WITH PLIERS	/REMOVE COTTER PINS 5 EACH	.00568		.034	
0030	E				GLM-FN-DA			4.00	REMOVE NUT AND WASHER	/4 EACH NUTS AND WASHERS	.00948		.045	
0040	E				KMP-TL-D5			2.00	REMOVE PART W/HAMMER & DRIFT	/REMOVE 2 SHAFT ENDS	.00305		.007	
0050	E				GNF-LR-D2			6.00	REMOVE LOCK RINGS OR KEEPERS	/REMOVE 6 LOCKRINGS	.00895		.064	
0060	E				RLG-DS-GC			1.00	REMOVE GLAND NUT	/	.02910		.035	
0070	E				KMP-TL-D5			3.00	REMOVE PART W/HAMMER & DRIFT	/REMOVE 3 INTERNAL PARTS	.00305		.011	
0080	E				GLM-AE-DA			2.00	REMOVE STAND-OFF OR SPACER	/REMOVE SHIMS 2 SETS	.00530		.012	
0090	E				GCF-EB-DA			9.00	REMOVE BEARING	/REMOVE 9 BEARINGS	.01437		.156	
0050			HB	01	21			1.00		ASSEMBLE JACK SHAFT	1.219	.256	1.475	34
0005	E				GCE-JP-T0			1.00	T.O. RESEARCH		.19359		.234	
0010	E				GCF-EB-AA			9.00	INSTALL BEARING	INSTALL BEARINGS	.03745		.407	
0020	E				GTE-ET-A5			2.00	INSTALL SHIMS	INSTALL SHIMS 2 EA	.01428		.034	
0030	E				KLU-SE-01			3.00	LUBE SPOT WITH BRUSH,ETC	LUBERCATE PARTS 3 EA	.00087		.003	
0040	E				RHY-AS-C1			1.00		INSTALL INNER PARTS	.61286		.741	
0050	E				RLG-AS-GC			1.00	INST PACKING GLAND NUT CONST/		.02279		.027	
0060	E				GNF-LR-A1			6.00	INSTALL LOCK RING OR KEEPERS/		.00289		.020	
0080	E				RLG-AM-05			2.00	INST MAT PT W/MALLET BLOWS	/2 EACH ENDS	.00212		.005	
0055			HB	01	00			1.00		CHECK ALIGNMENT	.109	.000	.109	3
0010	E				RLG-EI-AC			1.00	CHECK ALIGNMENT		.06483		.064	
0020	E				GLM-FN-AB			1.00	INSTALL NUT AND WASHER		.01692		.016	
0030	E				ANF-CP-A1			1.00	INSTALL COTTERPIN W/PLIERS		.00737		.007	
0040	E				GLM-FB-AA			1.00	INSTALL BOLT - NORMAL ACCESS		.01015		.010	
0050	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010	
9000			HB	01	21			.01		LABOR STANDARD HISTORY	.000	.000	.000	0
0010									PRIOR HISTORY ON 00-ALC 494 FORM					
0020									18FEB83 UPDATE OPERATION LINE-2 YEAR REVIEW 5.47					
0021									01AUG84 2 YEAR REVIEW <OLD STD> 5.46					
0022									24JUL85 2 YEAR REVIEW <OLD STD> 5.47					
0023									10FEB86 MOVE SUB OP 0040 TO OP PP010<OLD STD>5.47					
0024									31 MARCH 87 DELETED STEP 0020 SUBOP 0020 NO BLAST					
0025									DONE BY MNPGP, DELETED STEP 0070 SUBOP 0030 PAINT					
0026									DONE BY 3S SKILL CODE, ADDED STEPS 0020 & 0025					
0027									SUBOP 0020 NICK & BURR AND MOVE PARTS TO BLAST					
0028									ENGINEERED TIME STEP 0040 SUBOP 0030 INSTALL					
0029									INNER PARTS <OLD STD 5.13>					
0900									KERRY COOP MANEL TECHN 73357					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

OPER SUB STEP	TECH	S	S	W	F	PF	A/R	REV	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY
00010	E	N	HB	EA	5		J	88229	1.00	PERCENT ENGR .6	STRUT ASSY B-52M	10.71		10.71	
0001			HB	01		00			.00		PART NUMBER/NSN	.000	.000	.000	
0010										7027648-190	1620001398473				
0020										7027648-210	1620001398474				
0501			HB	01		21			1.00		PRE ASSY CLEAN	1.000	.210	1.210	
0010		N							1.00		CLEAN PARTS	1.00000		1.210	
0502			HB	01		21			1.00		ASSY INTERNAL PARTS	1.500	.315	1.815	
0010		N							1.00		ASSY PARTS	1.50000		1.815	
0504			HB	01		21			1.00		OK TO CLOSE/ASSEMBLE	3.000	.630	3.630	
0010		N							1.00		ASSEMBLE	3.00000		3.630	
0505			HB	01		21			1.00		CAM ALIGNMENT	.404	.085	.489	
0010		N							1.00		ALIGN CAM	.40400		.488	
0506			HB	01		21			1.00		CHECK STROKE	.500	.105	.605	
0010		N							1.00		CHECK STROKE	.50000		.605	
0507			HB	01		21			1.00		PRESSURE TEST	.493	.104	.597	
0010		N							1.00		TEST	.49300		.596	
0509			HB	01		21			1.00		TEST TRUNNION PORTS	.500	.105	.605	
0010		N							1.00		TEST PORTS	.50000		.605	
0510			HB	01		21			1.00		INSTALL STEERING BEARING	.304	.064	.368	
0010		N							1.00		INSTALL BEARINGS	.30400		.367	
			HB	01		00			1.00		INSTALL EXTERNAL PARTS	.750	.000	.750	
0010		N							1.00		INSTALL PARTS	.75000		.750	
0513			HB	01		00			1.00		CHECK STATUS OF PARTS ON 958	.250	.000	.250	
0010		N							1.00		SIGN OFF PARTS	.25000		.250	
0535			HB	01		25			1.00		FINAL ACCEPTANCE OF W.C.D.	.180	.045	.226	
0010		N							1.00		FINAL	.12800		.160	
0020		E					GJP-FP-B5		1.00		FILL OUT FORM 424 & ATTACH	.05255		.065	
0540			HB	01		25			1.00		FINAL VISUAL INSPECTION	.137	.034	.171	
0010		N							1.00		FINAL VISUAL INSPECTION	.12700		.158	
0020		E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
9000			HB	01		21			.01		LABOR STANDARD HISTORY	.000	.000	.000	
0010										PRIOR HISTORY ON 00-ALC 494 FORM					
0020										18FEB83 UPDATE OPERATION LINE-2 YEAR REVIEW	9.18				
0030										20OCT83 REVIEW <OLD STD>	9.18				
0031										01AUG84 2 YEAR REVIEW <OLD STD>	8.90				
0032										24JUL85 2 YEAR REVIEW <OLD STD>	8.90				
0033										20OCT86 ADDED TIME TO INSTALL PINS					
0034										& DROPED PAINT TIME OLD STD	8.90				

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17143A STRUT B-52 MLG RCC MMPGP 4S1-57-3

OPER SUB STEP	TECH D	S S T K L	W F PF #R A K C	A/R REV FA DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY
PP003	S	E 3S EA	5	J	88229	1.00	PERCENT ENGR 93.2	PAINT STRUT ASSY B-52	3.07		3.07	
0001		3S 01	00			.00		PART NUMBER/NSN	.000	.000	.000	
0010							7027648-190	1620001398473				
0020							7027648-210	1620001398474				
0515		3S 01	25			1.00		FINAL PAINT	2.391	.598	2.989	
0010	E		ZLG-HP-09			1.00	UNLOAD STRUT FROM CART		.02016		.025	
0020	E		ZLG-PF-04			1.00	PAINT & FINAL V/LARGE STRUT		1.61131		2.014	
0030	E		ZMA-MN-M1			1.00	MASK MED MLG STRUT FOR PAINT	ADDITIONAL MASK TIME	.09313		.116	
0050	E		ZMP-SP-P4			1.00	PRIMER PAINT V/LRG STRUT/PT		.15498		.193	
0060	E		ZMP-SP-P1			1.00	PRIMER PAINT SMALL STRUT	ADDITIONAL PRIMER PAINT	.08690		.108	
0070	E		ZMP-SP-F2			1.00	FINAL PAINT MED STRUT/PART	ADDITIONAL FINAL COAT	.25790		.322	
0080	N					1.00		FINAL VISUAL INSPECTION	.16700		.208	
0520		3S 01	25			1.00		DECALS	.072	.018	.090	
0010	E		RLG-JP-DS			1.00	GET STRUT DECALS F/STO CAB		.00693		.008	
0020	E		KID-DL-AA			4.00	INSTALL DECAL PR SENSITIVE	ADDITIONAL DECALS	.01378		.068	
0030	E		RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
9000		3S 01	25			.01		LABOR STANDARD HISTORY	.000	.000	.000	
0010							PRIOR HISTORY ON 00-ALC 494 FORM					
0020							18FEB83 UPDATE OPERATION LINE-2 YEAR REVIEW	2.82				
0021							01AUG84 2 YEAR REVIEW <OLD STD>	2.82				
0022							12OCT84 REWRITE STD <OLD STD>	2.82				
0023							24JUL85 2 YEAR REVIEW <OLD STD>	3.54				
0024							10FEB86 ADD SUB 0030 FOR PAINT JACKSHAFT	<OLD 3.54				

TO INTERROGATE LABOR STANDARDS, INPUT

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KC-135 MLG

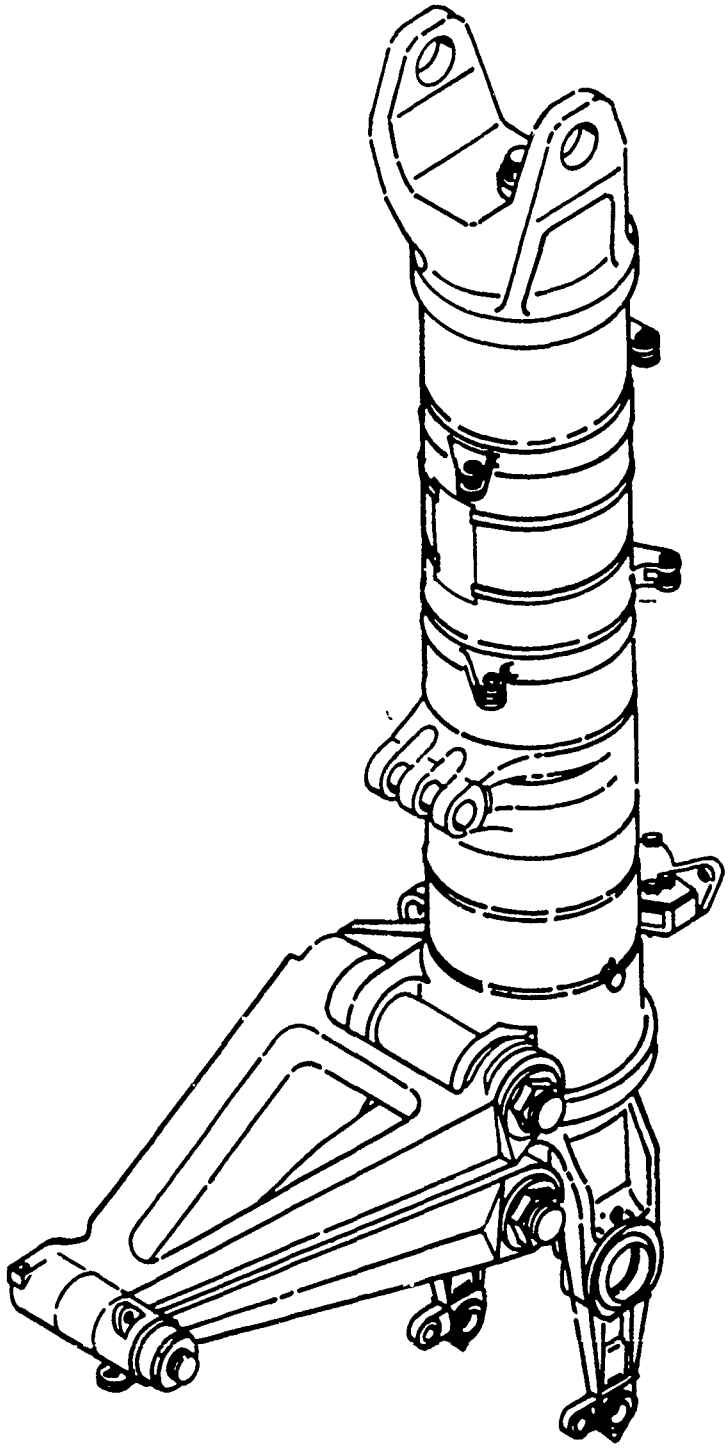


Figure 1-2. Main Gear Oleo Assembly

KEY TO FIGURE 2-1.

1.	Air Changing Valve	19A.	Shim (AR)	37.	Retaining Nut
2.	Plug & Bleeder	20.	Back-up ring	38.	Scraper
3.	Gasket	21.	Gasket	39.	Lower bearing nut
4.	Nut	22.	Cotter pin	40.	Nut
5.	Bolt	23.	Nut	41.	Clamp
6.	Bolt	24.	Screw	42.	Retaining Nut
7.	Lubefitting	25.	Retaining Nut	43.	Nut
8.	Up-Lock roller pin	26.	Piston head washer	44.	Bolt
9.	Bushing	27.	Upper bearing	45.	Insert
10.	Up-Lock roller	28.	Washer	46.	Plate
11.	Nut	29.	Spacer	47.	Rod
12.	Bolt	30.	Lower bearing	47A.	Bolt
13.	Door Operator bracket	30A.	Spacer	48.	Pin
14.	Nut	31.	Back-up ring	49.	Packing
15.	Washer	32.	T Seal	50.	Back-up ring
16.	Bolt	33.	Packing Adapter	51.	Fitting
17.	Lockplate	34.	Back-up ring	52.	Bushing
18.	Cotter pin	35.	T Seal	53.	Bushing
19.	Nut	36.	Feltwipe	54.	Bushing
				55.	Bushing
				56.	Bushing
				57.	Inner Cylinder
				58.	Bushing
				59.	Bushing
				60.	Fitting
				60A.	Retainer
				61.	Bushing
				62.	Bushing
				63.	Bushing
				64.	Outer Cylinder

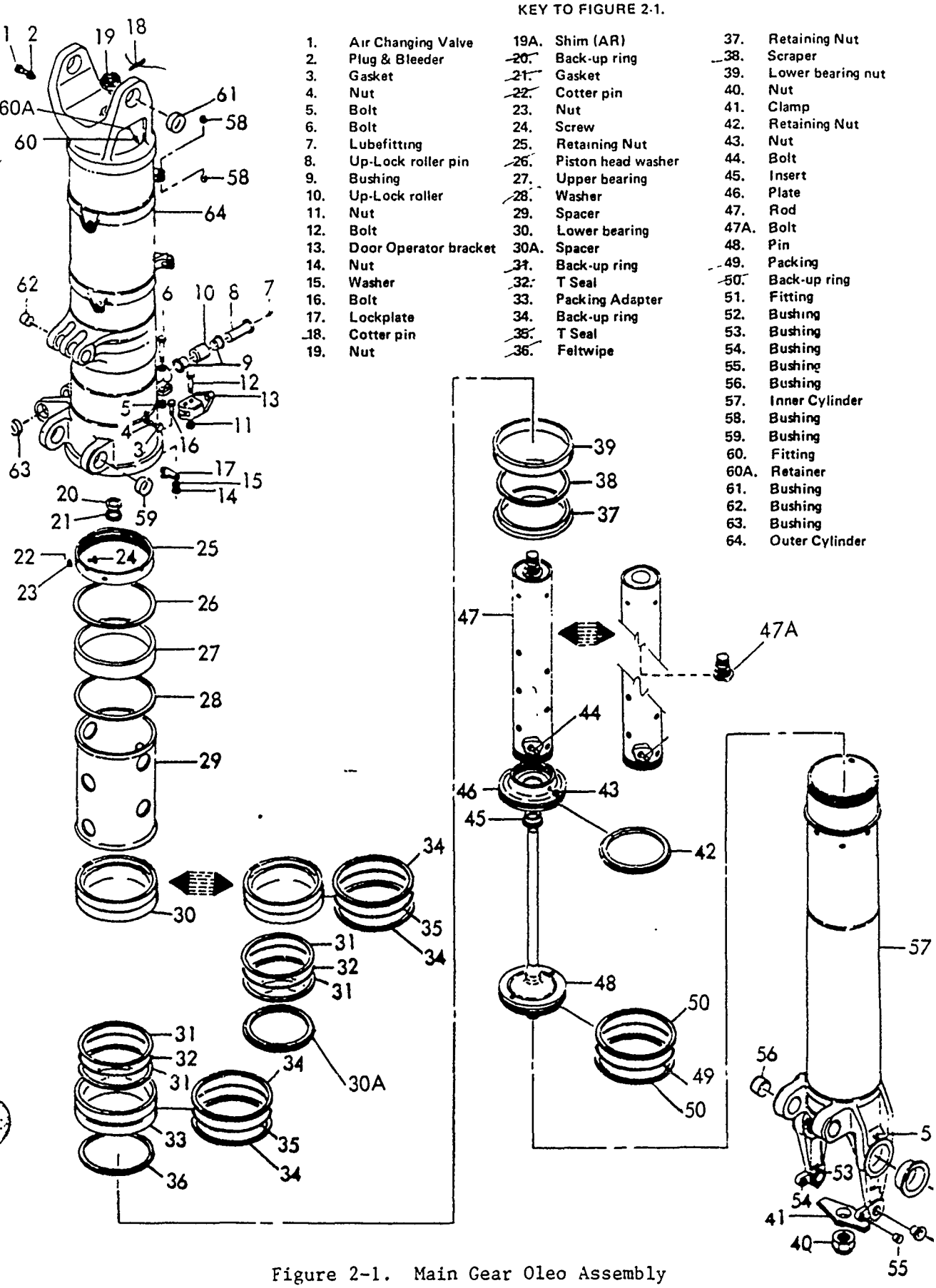


Figure 2-1. Main Gear Oleo Assembly

KEY TO FIGURE 2-2.

30.	Nut	46.	Bolt	60.	Bolt
31.	Bolt	47.	Nut	61.	Deleted
32.	Nut	48.	Washer	62.	Bolt
33.	Washer	49.	Washer	63.	Bushing
34.	Bolt	50.	Bolt	64.	Spacer Assy
35.	Spacer	51.	Shim	65.	Nut
36.	Plug	52.	Shim	66.	Bolt
37.	Nut	53.	Spacer half	67.	Nut
38.	Bolt	54.	Spacer half	68.	Washer
39.	Bolt	55.	Spacer	69.	Bolt
40.	Spacer	56.	Nut	70.	Fitting
41.	Bushing	57.	Bolt	71.	Bushing
42.	Spacer Assy	58.	Nut	72.	Bushing
43.	Nut	59.	Washer	73.	Link
44.	Washer				
45.	Washer				

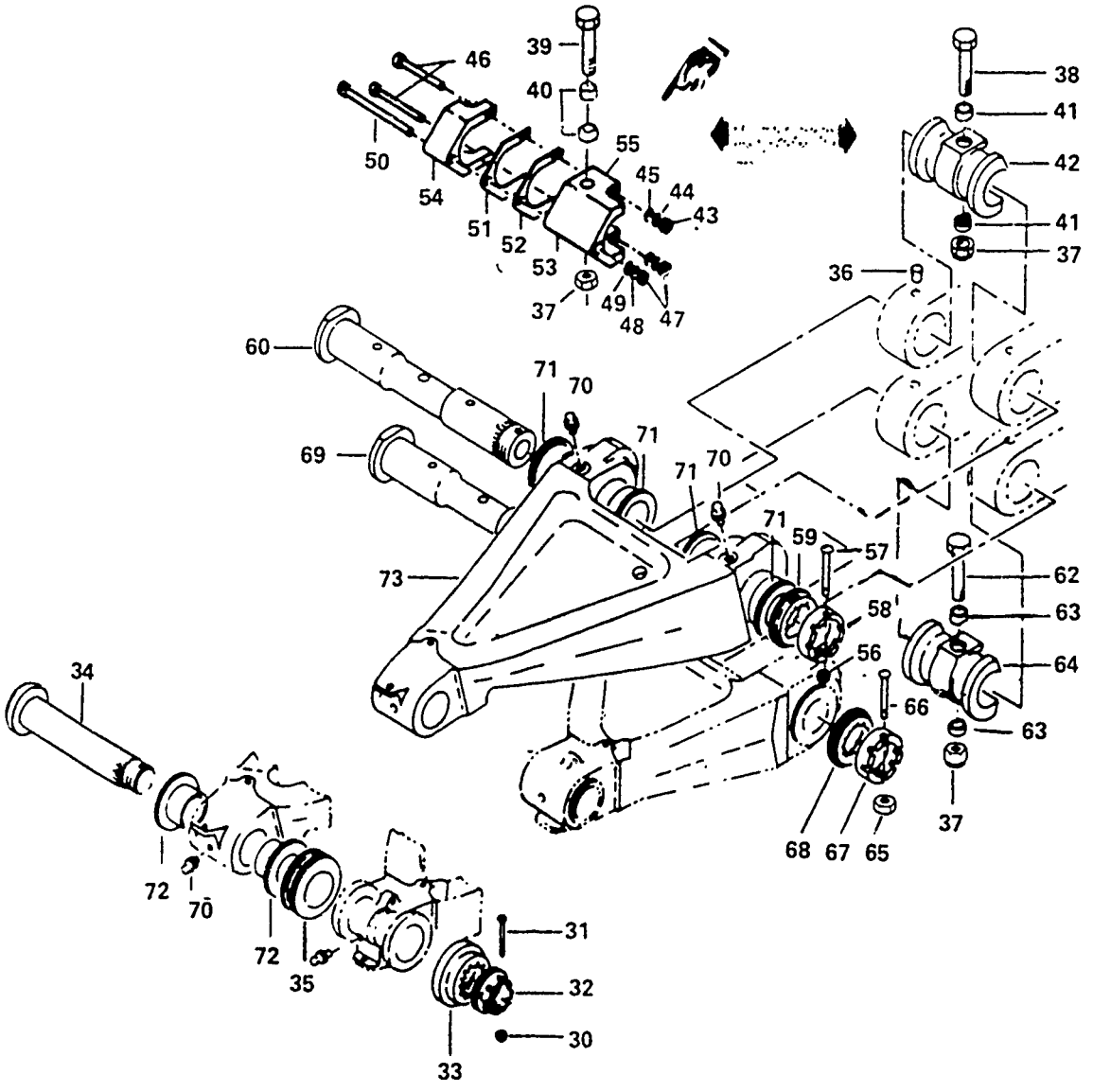
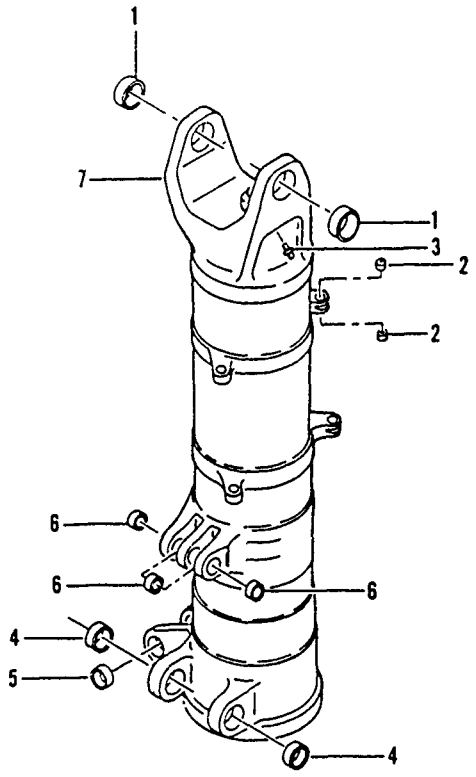


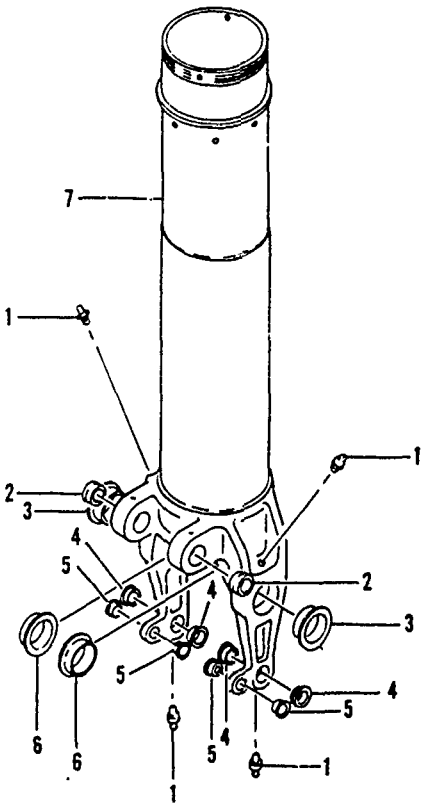
Figure 2-2. Torsion Link Assembly



KEY TO FIGURE 2-3

1. BUSHING	4. BUSHING
2. BUSHING	5. BUSHING
3. LUBRICATION FITTING	6. BUSHING
	7. OUTER CYLINDER

Figure 2-3. Outer Cylinder Assembly



KEY TO FIGURE 2-4

1. LUBRICATION FITTING	4. BUSHING
2. BUSHING	5. BUSHING
3. BUSHING	6. BUSHING
	7. INNER CYLINDE

Figure 2-4. Inner Cylinder Assembl

KEY TO FIGURE 2-5

1 PISTON ROD RING
2 NUT
3 BOLT
4 ORIFICE PLATE INSERT
5 ORIFICE PLATE
6 PISTON ROD
7 BOLT

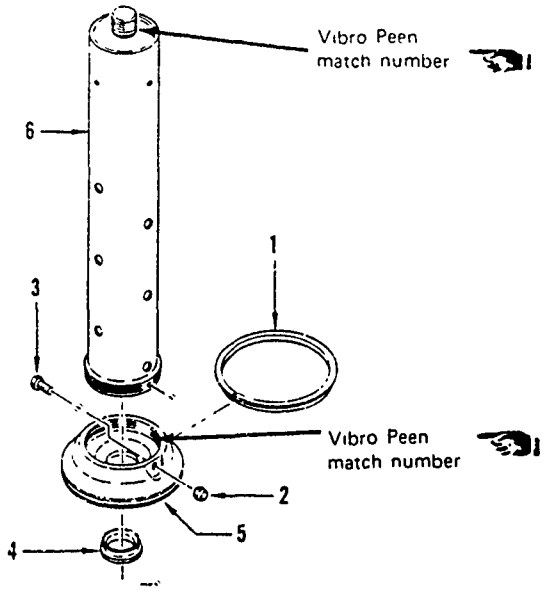
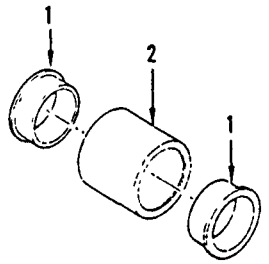


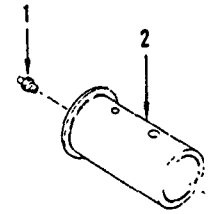
Figure 2-5. Piston Rod Assembly



KEY TO FIGURE 2-6

1. BUSHING
2. ROLLER

Figure 2-6. Up-Lock Roller Assembly



KEY TO FIGURE 2-7

1. LUBRICATION FITTING
2. UP-LOCK ROLLER PIN

Figure 2-7. Up-Lock Roller Pin Assembly

SECTION I

INTRODUCTION

1-1. IDENTIFICATION. The Main Gear Oleo Assembly is a compression strut which absorbs takeoff and landing impact shocks, and is the principal structural member of the main landing gear of the airplane. See figure 1-1 for leading particulars of the Main Gear Oleo Assembly.

Type	Air-Oil
Fluid	Hydraulic Fluid, Specification MIL-H-5606
Length	
Compressed	67.19 Inch
Taxi	70.19 Inch
Extended	89.19 Inch
Weight	600 Pounds

Figure 1-1. Leading Particulars

1-2. CONTENTS. This technical manual contains overhaul, inspection, and test instructions for the Main Gear Oleo Assembly, part Nos. 65-1263, all dash numbers, and 7531273, all dash numbers, manufactured by The Boeing Company, Renton, Washington. Information in this manual will enable overhaul personnel to return the Main Gear Oleo Assembly to a condition that meets all original design requirements while maintaining component parts interch ability. Overhaul, reassembly, and instructions are provided in Sectio VI, VII and VIII.

1-3. HOW TO USE MANUAL. The follo instructions are recommended as a g for maximum utilization of this man

a. Consult figure 1-3 for index chart of landing gear parts.

b. Perform all operations, as f as possible, in accordance with seq as given, i.e., disassemble, clean strip paint, inspect, etc.

c. Identify basic material of e component. Basic material is that metal used for part fabrication and constitutes main structure foundati See figure 6-1 for Material Identif cation Chart.

CAUTION

Steel parts heat-treated 220 ksi and above require strict adherence to rework instruction. Improper rework procedures can expose these parts to early failures. It is recommended that parts in the 220 ksi and above heat-treat range be tagged for easy identification.

STL=STEEL
AL=ALUMINUM
MAG=MAGNESIUM
TITA=TITANIUM
SS=S STEEL
SYN=SYNTHETIC
LD=LEAD

KC-135 MAIN STRUT (L.H.)

BILL OF MATERIALS

69657A

* = MMI

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	0	7531273-90	1620010389102	81205	KC-135 MAIN STRUT ASSEMBLY (L.H.)	1	EA										
	1	AN813-1	1650002224525	96906	.CAP, VALVE	1	EA										
	1	MS28889-1	4820005356483	96906	.VALVE, CHARGING	1	EA										
	1	AN814-6L	5365002788800	88044	.PLUG & BLEEDER	1	EA										
	1	AN6290-6	5330008045695	88044	.GASKET (O-RING)	1	EA										
	1	MS28778-6	5330008045695	96906	.PACKING, PREFORM	1	EA					SUB					
	1	MS67985	5310008071476	80205	.NUT, LOCKING	.4	EA										
	1	AN175-26A	5306001821954	88044	.BOLT, MACHINE	1	EA										
BTL	1	7729141-10	1620010596842	98747	.UPLOCK PIN ASSEMBLY	1	EA										
	2	MS15001-1	4730000504203	96906	..FITTING, GREASE	1	EA										
BTL	2	7729141-01	N.S.L.	98747	..PIN, UPLOCK	1											
	2	130-3103	1620005725312	81205	..ROLLER ASSEMBLY	1	EA										
	3	130-3102	3120008029341	81205	...BUSHING	1	EA										
	3	130-3101	N.S.L.	81205	...ROLLER	1											
		MS67697	N.S.L.	80205	.NUT, LOCKING	2											
		AN7-22A	5306002085062	88044	.BOLT, MACHINE	2	EA										
		169-1173-1	1620006020297	81205	.BRACKET, DOOR	1	EA										
		MS9516	5310001670820	88044	.WASHER, FLAT	2	EA										
		AN5-7A	5306001509102	88044	.BOLT, MACHINE	2	EA										
	1	130-3115-3	1620007958724	81205	.PLATE, LOCK	1	EA										
	1	MS24665-5-40	N.S.L.	80205	.PIN, COTTER	1											
	1	130-3112	5310005934352	81205	.NUT, PLAIN (PISTON ROD)	1	EA										
	1	55966-2812	5310010260818	56878	.NUT, LOCKING (PISTON ROD)	1	EA					SUB					
	1	175-1	5330005769589	13002	.RETAINER (BACKUP-RING)	1	EA										
	1	169-4230-5	N.S.L.	81201	.RETAINER (BACKUP-RING)	1						INT					
		169-4081-3	5330007268414	81205	.RETAINER (BACKUP-RING)	1	EA					INT					
		AN6230-1	5330000546859	88044	.GASKET (O-RING)	1	EA										
		MS24665-2-8	5315008151405	10001	.PIN, COTTER	4	EA										
		MS20-5	5310001768109	88044	.NUT, CASTLE	4	EA										
		130-3109	5305005766726	81205	.SCREW (PISTON HEAD NUT)	4	EA										
	1	AN960-516L	5310001670836	98747	.WASHER, FLAT	4	EA										
	1	190-0665	5310005676817	81205	.NUT, PISTON HEAD	1	EA										
	1	160-6537	5365005501826	81205	.WASHER, SPACER (ALUMINUM)	1	EA										
	1	160-6536	3120005541887	81205	.BEARING UPPER	1	EA										
	1	160-6538	5365005541968	81205	.WASHER, SPACER (STEEL)	1	EA										
	1	165-5754-1	1620007651370	81205	.SPACER, PISTON	1	EA										
	1	165-5754	N.S.L.	81205	.SPACER, PISTON	1						INT					
	1	17653528-01	3120010403938	98747	.BEARING, LOWER	1	EA										
	1	17653529-01	5365010396536	98747	.SPACER (LOWER BEARING)	1	EA										

STL=STEEL
AL=ALUMINUM
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SS=S STEEL
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KC-135 MAIN STRUT (L.H.)

BILL OF MATERIALS

69657A

* = MMI

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
BRASS	1	MS28776M2-65	1650000599577	96906	.SCRAPER, RING	1	EA										
STL	1	69-11808	5310007912952	81205	.NUT, PACKING (GLAND)	1	EA										
STL	1	142MTU2812	5310006259987	72962	.NUT, LOCKING	1	EA										
STL	1	359A6-2812	5310010260818	56878	.NUT, LOCKING	1	EA					INT					
AL	1	190-8454	1620005725325	81205	.CLAMP, BULKHEAD (PIN RETAINER)	1	EA										
	1	7531269-30	1620010273442	81205	.ROD ASSEMBLY	1	EA										
BRASS	2	160-6531	1620005542622	81205	..RING, PISTON	1	EA										
	2	MA967W5	5310008071476	80205	..NUT, LOCKING	1	EA										
	2	AN5-11A	5306001509103	88044	..BOLT, MACHINE	1	EA										
STL	2	69-1176	N.S.L.	81205	..PLATE ASSEMBLY (CAP)	1											
	3	130-3111	1620005725313	81205	...INSERT, ORIFICE	1	EA										
	3	69-1176-1	N.S.L.	81205	...PLATE (CAP)	1											
	2	7531268-03	N.S.L.	81205	..ROD	1											
	2	MS24479B-47	5305000512352	81205	..SCREW, MACHINE (TAPERED HEAD)	2	EA										
	2	7531267-01	N.S.L.	81205	..BOLT (ROD ASSEMBLY)	1											
	2	7531267-1	1620010364298	98747	..BOLT (ROD ASSEMBLY)	1	EA					SUB					
	1	165-5735	1620007390166	81205	.PIN, METERING	1	EA										
	1	44A7HT-160A-N	5330010056111	72902	.SEAL ASSEMBLY	1	EA										
	2	44A7HT-160A	N.S.L.	72902	..PACKING (T-SEAL)	1											
	2	44A7HT-2N	N.S.L.	72902	..RETAINER (BACKUP-RING)	2											
		[illegible]	1620000842104	81205	.INNER CYLINDER ASSEMBLY	1	EA										
		[illegible]-1	4730000504203	96906	..FITTING (GREASE)	4	EA										
		N.P.L.	N.S.L.		..INNER CYLINDER SUBASSY	1											
		160-6534	N.S.L.	81205	...BUSHING (TRUCK ATTACH)	4											
		166-10615-1	3120004397149	81205	...BUSHING (TRUCK ATTACH) (O.S.)	4	AR	EA				ALT					
		130-3110	3120005557464	81205	...BUSHING (EQUALIZER ATTACH)	4		EA									
		A67C30560	N.S.L.	98747	...BUSHING (EQUALIZER ATTACH) (O.S.)	4	AR					ALT					
		MA977A10-44P	3120008032093	80205	...BUSHING (SNUBBER ATTACH)	2		EA									
		67C30359-1	N.S.L.	98747	...BUSHING (SNUBBER ATTACH) (O.S.)	2	AR					ALT					
		MA977A10-50P	3120008827612	80205	...BUSHING (SNUBBER ATTACH)	2		EA									
		67C30359-3	N.S.L.	98747	...BUSHING (SNUBBER ATTACH) (O.S.)	2	AR					ALT					
		166-11340	3120009765949	81205	...BUSHING (TORQUE ARM ATTACH)	2		EA									
		7530995-01	3120010132445	98747	...BUSHING (TORQUE ARM ATTACH) (O.S.)	2	AR	EA				ALT					
		165-1265-5	N.S.L.	81205	...INNER CYLINDER	1											
	1	165-1265-7	1620009816337	81205	.INNER CYLINDER ASSEMBLY	1		EA				SUB					
	2	MS15001-1	4730000504203	96906	..FITTING, GREASE	4		EA									
	2	N.P.L.	N.S.L.		..INNER CYLINDER SUBASSY	1											
	3	160-6534	N.S.L.	81205	...BUSHING (TRUCK ATTACH)	4											
	3	166-10615-1	3120004397149	81205	...BUSHING (TRUCK ATTACH) (O.S.)	4	AR	EA				ALT					
	3	130-3110	3120005557464	81205	...BUSHING (EQUALIZER ATTACH)	4		EA									

STL=STEEL
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TITA=TITANIUM
CRES=CRES STEEL
PHN=PHENOLIC
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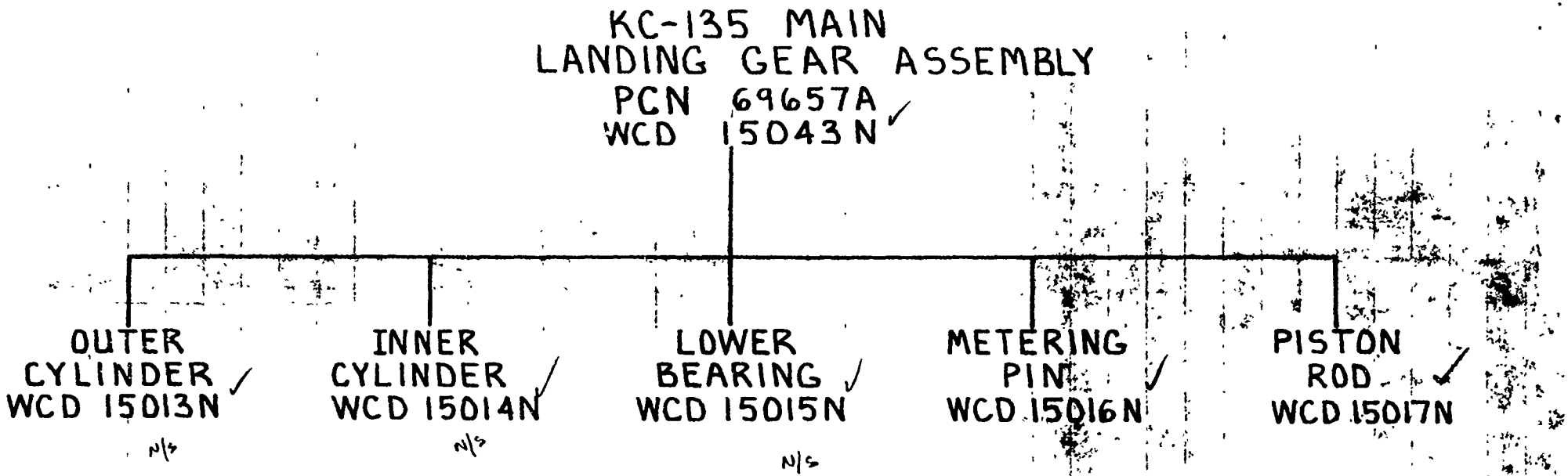
KC-135 MAIN STRUT (L.H.)

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* = MMI

INDENTED ITEM	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE A,B,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
		65-[illegible]-17	1620009274739	81205	.OUTER CYLINDER ASSEMBLY	1	EA										
		[illegible]-1	4730002774780	80205	..FITTING (GREASE)	2	EA										
		7629[illegible]-01	N.S.L.	81205	..SHIM (UPLOCK BOSS)(1ST REPAIR)	1	AR										
		65[illegible]315-71	3120010597815	98747	..SHIM (UPLOCK BOSS)(2ND REPAIR)	1	AR	EA				ALT					
		N.P.L.	N.S.L.	....*	..OUTER CYLINDER SUBASSY	1											
		[illegible]-4-008	3120002876991	80205	...BUSHING (DOOR ATTACH)	8	EA										
		7127[illegible]10	3120010468135	98747	...BUSHING (TORQUE ARM ATTACH)	2	EA										
		66-[illegible]032-1	3120008209603	81205	...BUSHING (TRUNNION LUGS)	2	EA										
		[illegible]23-01	3120000612177	98747	...BUSHING (TRUNNION LUGS)(O.S.)	2	AR	EA				ALT					
		66-29034-2	N.S.L.	81205	...BUSHING (DRAG STRUT LUGS)	3											
		66-29034-1	3120000517210	98747	...BUSHING (DRAG STRUT LUGS)	3	EA					SUB					
		[illegible]45-979-999	N.S.L.	98747	...BUSHING (DRAG STRUT LUGS)(O.S.)	3	AR					ALT					
		66-29035-1	3120000528405	81205	...BUSHING (SIDE BRACE LUG)	2	EA										
		65[illegible]315-70	3120010556425	98747	...BUSHING (SIDE BRACE LUG)(O.S.)	2	AR	EA				ALT					
		N.P.L.	N.S.L.	....*	...BUSHING&PACKING ASSEMBLY (PSEUDO)	1	AR										
		4508[illegible]-02	N.S.L.	98747	....BUSHG(4130 STL ORIFICEBOSS(REPR)	1								*			
		[illegible]975-226	5330005769732	96906	....PACKING (O-RING)(REPAIR)	1	EA										
		65-5263-19	N.S.L.	81205	...OUTER CYLINDER	1											


KC-135 MAIN
LANDING GEAR ASSEMBLY
PCN 69657A
WCD 15043 N
OUTER
CYLINDER
WCD 15013N
N/S
INNER
CYLINDER
WCD 15014N
N/S
LOWER
BEARING
WCD 15015N
N/S
METERING
PIN
WCD 15016N
PISTON
ROD
WCD 15017N

FAMILY 3

CONTROL NUMBER LIST

LABO TECH	PLAN TECH	CONTROL NUMBER	JOP DESC	AIRCRAFT		DESCRIPTION	STOCK NUMBER	PART NUMBER	TECHORDE
DELE		69568A		C-130	NLG	PISTON	1620-00-954-8008	25 NOV 86	4S2-23-3
BENT	POLL	69569A		C-130	NLG	TORQUE STRUT ASSY	1620-00-005-8495	388064-1	4S1-69-13
DELE		69572A		C-130	NLG	CYLINDER	1620-00-623-8912	25 NOV 86	4S1-37-3
COOP	POLL	69573A		C-130	NLG	TORQUE STRUT	1620-00-623-8913	388065-7	4S1-69-13
BENT	POLL	69577A		C-130	NLG	BRACE ASSY	1620-00-976-3391	371689-12	4SA6-7-3
BENT	POLL	69578A		C-130	NLG	STRUT ASSY	1620-01-143-1155	7926487-30	4S2-23-3
JENS	PRIC	69589A	-J	F-100	NLG	WHEEL	1630-00-067-4924	3-1080	4W3-7-1023
JENS	PRIC	69591A	-J	F-100	NLG	WHEEL	1630-00-696-3570	218A381	4W3-7-1293
RIGB	PRIC	69595A	✓	B-52		MAIN WHEEL	1630-00-212-0942	3-1192-1	4B1-4-133
DELE		69602A		F-106		GONE SWITCH	1440-00-942-1047AA	11 JULY 86	11L1-3-14-1
COVI	SHEL	69603A		F-111		INERTIA REEL	1377-01-141-8911	0103157-77	11P9-11-3
MART	SHEL	69621A		A-37		CONTROL BOX ASSY	1005-00-051-8781	DCK-144A378-9	11W1-15-12-
BENT	POLL	69626A		C-130	NLG	STRUT ASSY	1620-00-505-1184	3303591-3	4S2-23-3
BENT	POLL	69651A		C-130	NLG	STRUT ASSY	1620-00-623-8911	370438-1	4S1-37-3
BENT	POLL	69652A		C-130	NLG	STRUT ASSY	1620-00-111-1418	695001-9A	4S1-37-3
BENT	POLL	69653A		C-130	NLG	COLLAR	1620-00-697-0191	352604	4S2-23-3
JENS	RIGB	69654A	-G-J	F-1		BRAKE ASSY	1630-01-118-3642	5003063-6	4B1-2-1163
JENS	POLL	69655A	-G-J	C-130		BALLSCREW	1620-01-065-4867	8430M2	1663-2-87-3
BENT	COOP	69657A	✓	KC-135	NLG	STRUT ASSY L/H	1620-01-038-9102	7531273-99	4S1-56-
BENT	COOP	69658A		KC-135	NLG	STRUT ASSY R/H	1620-01-038-9101	7531273-100	4S1-56-3
DELE		69697J		C-141	NLG	ORIFICE TUBE	1620-00-202-5315	2 JAN 85	4S1-73-3
COOP	COOP	69707A		F-15	NLG	LOWER BRACE	1620-00-305-1849	68A450771-1001	4S2-73-4
COOP	POLL	69775A	-G	C-141	NLG	ROOT PIN	5315-00-500-6801LE	7430214-01	4S1-Z3-3
COOP	TOLM	69777A		B-52	NLG	LOWER LINK	1620-00-217-4961	1-80604	4S1-28-4
JENS	PRIC	69794A	-J	F-15	NLG	WHEEL	1630-01-141-4695	5000864-9	4W1-8-73
MONR	TOLM	69803A		CH-3	NLG	STRUT ASSY	1620-01-168-0338	8341139-10	4S2-58-3
JENS	RIGB	69807A	-J	F-15	NLG	A/B BRAKE ASSY	1630-01-018-2118	5000913-10	4B1-2-1123
MONR	ANDE	69825A		C-5A	NLG	UPPER BEARING	3120-00-251-7338LE	78869	4S2-67-3
DELE		69826A		F-16	NLG	DRAG STRUT	1620-01-101-1700	16 APR 86	4SA6-32-3
COOP	TOLM	69833A		F-111	NLG	STRUT ASSY-SHOCK HW	1620-01-103-1950	1130100-503	4S1-87-3
DELE		69834A		F-16	NLG	DRAG STRUT	1620-01-078-9360	26MAR 86	4SA6-32-3
DELE		69853A		B-52		BOX END CROSSOVER	1005-00-898-9671	28 OCT 86	11F8-3-7-3
COOP	TOLM	69855A	✓ -G	B-52	NLG	STEERING PLATE	1620-00-605-2768	5-68457-5	4S1-57-3
MART	SHEL	69857A		A-10		EQUALIZER GAU-8	1005-01-055-0315	205F469	11W1-7-14-3
DELE		69865A		A-10		DRUM ASSY GAU-8	1005-01-003-1436	05-20-87	11W1-7-14-3
DELE		69873A	-J	C-47	NLG	BRAKE	1630-00-959-2052	25 NOV 86	4B1-5-23
DELE		69875A		F-111	NLG	UPPER TRUNNION ASSY	1620-01-065-3417	10 OCT 88	4A4-15-3
COOP	TOLM	69887A		B-52	TIP	OUTER CYLINDER	1620-00-705-7261	5-96453-501	4S6-2-3
MONR	ANDE	69898A		C-5A	NLG	FORWARD DRAG LINK	1620-00-115-7433	4651437-107A	4S2-67-3
MONR	ANDE	69899A		C-5A	NLG	LOWER BEARING	3120-00-158-1799LE	4694453-101B	4S2-67-3
DELE		69915A		B-52		AMMO CAN	1005-00-21.-3225	28 OCT 86	11W1-34-3-1
DELE		69928A		F-16	NLG	STRUT ASSY	1620-01-098-2749	20 FEB 87	4S2-88-3
CALD	TOLM	71069A		F-111	NLG	LINK ASSY	1620-00-415-0280	12L9548-13	4A4-15-3
DELE		72827A		C-5A	NLG	COMP. LINK	1620-00-109-1076	12 DECEMBER 86	4S1-94-3
DELE		72836A		C-5A	NLG	LOWER SIDE BRACE ARM	1620-00-115-7387	5-OCT-87	4S1-93-3
DELE		72846A	-G	C-5A	NLG	FLUID TRANS HOUSING	1620-00-115-7419	12 DECEMBER 86	4S1-93-3
MONR	ANDE	72848A		C-5A	NLG	UPPER TORQUE ARM	1620-00-115-7431	4651432-101A	4S2-67-3
MONR	ANDE	72852A		C-5A	NLG	TRUNNION PIN	1620-00-116-2099	4612400-101A	4S1-93-3
MONR	ANDE	72877A	-G	C-5A	NLG	STRUT ASSY	M 1620-00-432-5651	4651403-103G	4S2-67-3
MONR	ANDE	72879A		C-5A	NLG	OUTER CYLINDER	M 1620-00-446-3776	4611415-107A	4S1-93-3

(G402A-TIP001) LABOR STD REVIEW 10-APR-89 4:38 PM

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
[redacted]	MNPGP	UUU1U	N	HS	5	o.10	1.00	6.10
		PP043	E	3S	5	1.53	1.00	1.63
								7.73
FAMILY 3	*							
KC-135 MLG	MNPGW	PM043	N	DJ	5	.98	1.00	98
		WC001	E	KI	5	1.62	1.00	1.62
		WD001	E	HB	5	3.09	1.00	3.09
		WE013	N	DI	5	1.80	1.00	1.80
		WE014	N	DI	5	.88	1.00	88
		WE015	N	DI	5	.17	1.00	17
		WE01o	N	DI	5	.13	1.00	13
		WE017	E	DI	5	.08	1.00	8
		XNPGW	X	HB	5	1.94	1.00	1.94
								10.69
	*							
	MNPNA	NA013	E	DB	2	1.20	1.00	1.20
		NA014	E	DB	2	1.05	1.00	1.08
		NA01o	E	DB	2	.15	.35	5
		XNPNA	X	DB	2	2.60	1.00	2.60
								4.93
	*							
	MNPRA	RA013	E	JA	1	9.14	.05	45
		RA014	E	JA	1	7.29	.05	36
		RA015	N	JA	1	2.63	.20	52
		RA017	E	JA	1	.22	1.00	22
								1.55
	*							
	MNPRB	RB013	N	JA	3	13.87	.05	69
		RB014	E	JA	3	9.99	.05	49
								1 18
	*							
	MNPRC	RC013	E	UP	B	5.19	.05	25
		RC014	N	UP	B	5.55	.05	27
		RC015	E	UP	B	.54	.35	18
		RC01o	E	UP	B	.36	.35	12
		XNPRC	X	UP	B	2.09	1.00	2.09
								2.91
	*							
	*							[redacted]

15043N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 88152 | 1 PAGE__OF__PAGES

2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
		MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO
	4S-1-182 4S1-56-3	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
KC-135 MLG		25325A 69657A 25326A 69658A

13 SERIAL NUMBER	14 NOUN
	STRUT ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED		18. MECHANIC	19. "P"	20. "Q"
P/N		NSN	C/N			
7531273-80		1620010389103	25325A			
7531273-70		1620010389100	25326A			
7531273-90		1620010389102	69657A			
7531273-100		1620010389101	69658A			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT				
		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND				
		T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH				
		THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH				
		STATIONS. WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF				
		EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO				
		PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA (CONTINUED)				

21 FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15043N
		B	D	

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15043N * WORK CONTROL DOCUMENT (MEDS)

DATE [redacted]88152

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2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 *OPTIONAL

13 SERIAL NUMBER	14 NOUN
	STRUT ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		STAMP.			
	001	7531273-70 7531273-80 7531273-90 7531273-100			
	010	*MATCH-UP* ----------ROUTED COMPONENTS---------- NEW/SERVICEABLE REWORK NO REWORK		001 MNHGP 002 06 003 MU01	
		OUTER CYLINDER 15013N INNER CYLINDER 15014N			
		BEARING (LOWER) 15015N PIN, METERING 15016N			
		PISTON ROD 15017N			
	500	FINAL ACCEPTANCE OF WCD PACKAGE FOR COMPLETNESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 950 *C/P MOVE		001 MNHGP 002 06 003 SA03	
	501	PRE ASSY CLEANING INSPECTION CHECK CAVITIES & INTERIOR FOR FORIEGN MATERIAL PRIOR TO REASSEMBLE *C/P MOVE		001 MNHGP 002 06 003 SA03	
	502	OK TO CLOSE AND/OR ASSEMBLE I.A.W. T.O. 4S1-56-3 *C/P MOVE		001 MNHGP 002 06 003 SA03	
	504	TORQUE ALL NUTS, BOLTS, AND SCREWS AS REQUIRED I.A.W. T.O. 4S1-56-3		001 MNHGP 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15043N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1966—646-183

15043N **WORK CONTROL DOCUMENT (MEDS)** 1. DATE 88152 PAGE 3 OF 3 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	STRUT ASSY

15. DISPATCH STA	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	505	CHECK STROKE IAW T.O. 4S1-56-3 *C/P MOVE		001 MNP GP 002 06 003 SA03	
[redacted]	506	PRESSURE TEST I.A.W. T.O. 4S1-56-3 *C/P MOVE		001 MNP GP 002 06 003 TL07	
[redacted]	510	MASK, PRIME AND PAINT *C/P MOVE		001 MNP GP 002 09 003 WB03	
[redacted]	512	DECALS *C/P MOVE		001 MNP GP 002 09 003 WB03	
[redacted]	515 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNP GP 002 09 003 WB03	
[redacted]	516 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNP GP 002 09 003 WB03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15043N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1988—548-163

15013N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89037 | PAGE 1 OF ___ PAGES

2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.
	4S-1-182 4S1-56-3	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
KC-135 MLG		69657A 69658A 25326 25325A

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED			18. MECHANIC	19. "P"	20. "Q"
P/N		NSN	C/N				
65-5763-17		1620009274739	[illegible]	L / H			
65-5763-18		1620009592078	69658A	R / H			
50-9712-32		1620007871750	25325A	R / H			
50-9712-31		1620007871749	25326A	L / H			
		***UNIT COST		$49579.05***			
		GOVERNING DIRECTIVES:		AFLCR 66-51 MANDI 66-3			
		BLAST	IAW	MIL-STD-1504			
		NICKEL PLATE	IAW	MIL-STD-868			
		FMPI	IAW	MIL-STD-1949 P/O NO1561			
		FPI	IAW	MIL-STD-6866			
		CAD PLATE	IAW	MIL-STD-870			
		CHROME PLATE	IAW	MIL-STD-1501			
		TEMP ETCH	IAW	MIL-STD-867			
		SHOTPEEN	IAW	MIL-S-13165			
		GRIT BLAST	IAW	MIL-STD-1504			
		BAKE	IAW	4S-1-182 MADI 74-12			
		IVD ALUM PLATE	IAW	MIL-C-83488A			
		ALODINE	IAW	MIL-C-5541			
		***STEEL - AMS 6407		220/240 KSI***			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY (CONTINUED)					

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15013N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1988—548-125

15013N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89037 | PAGE 2 OF ___ PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 *OPTIONAL*

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		"WARNING" MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS			
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	65-5763-17 65-5763-18 50-9712-32 50-9712-31			
[redacted]	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNPGW 002 02 003 LG02 005 X8745233	
				006 X8745183	
[redacted]	007 *REQD*	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 SL01	
[redacted]	009 *REQD*	BLAST CLEAN ONLY *C/P MOVE		001 MNPGW 002 03 003 BL01	
[redacted]	011 *REQD*	BAKE 4HRS AT 350-400F DATE IN_____TIME IN_____ (CONTINUED)		001 MNPGW 002 03 003 BK03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15013N.
		B	D	

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WORK CONTROL DOCUMENT (MEDS)

1. DATE 85037 | PAGE __ OF __ PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM AL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN	
	OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]	*RCOD*	*C/P MOVE		001 MNRNA 002 05 003 ML04	
24E	050 *REQD*	E & J **NOTE: HAND TYPE POWER TOOLS SHALL NOT BE USED TO REPAIR DAMAGE OR CORROSION PAGE 6-4, PARA 6-70.		001 MNRGW 002 04 003 EI01	
		LOWER BORE 11.00/11.003 IN WEAR 11.005 IN REPAIR MAX 11-040 IN			
		UPPER BORE 10.625/10.630 IN WEAR 10.682 IN REPAIR MAX 10.680 IN			
		******TRUNNION LUGS****** I.D. 2.687/2.689 IN WEAR 2.691 IN REPAIR MAX 2.820 IN			
		LUG WIDTH 1.24/1.26 IN REPAIR MIN 1.20/1.22 IN			
		FACE TO FACE 9.500/9.505 IN REPAIR MAX 9.540/9.545 IN OVERALL 11.980/12.025 IN			
		REPAIR MIN 11.940/11.985 IN ****DRAG STRUT LUGS (BASE METAL)****			
		I.D. 1.625/1.626 IN. REPAIR MAX 1.806 IN (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15013N
		B	D	

☆ U.S. GOVERNMENT PRINTING OFFICE: 1985—466-163

15013N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89037 | PAGE 4 OF PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN	
	OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		BUSHING I.D. 1.500/1.501 IN WEAR 1.502 IN			
		CENTER LUG WIDTH .996/.998 IN REPAIR MIN .996/.998 IN OUTSIDE LUGS WIDTH .99/1.01 IN			
		REPAIR MIN .96/.98 IN FACE TO FACE 1.312/1.314 IN REPAIR MAX 1.342/1.344 IN			
		*******SIDE BRACE LUGS******* I.D. 2.125/2.126 IN REPAIR MAX 2.185 IN			
		BUSHING I.D. 2.000/2.002 WEAR 2.004 IN LUG WIDTH .87/.89 IN			
		REPAIR MIN .855/.875 IN (INSIDE FACE ONLY) FACE TO FACE 4.000/4.004 IN			
		REPAIR MAX 4.035 IN *******TORQUE ARM LUGS******* I.D. 2.625/2.626 IN			
		REPAIR MAX 2.677 IN BUSHING 2.500/2.502 IN WEAR 2.504 IN			
		OVERALL 9.120/9.124 IN REPAIR MIN 9.080/9.084 IN			
		BOLT HOLE .639/.646 IN *******UPLOCK SOCKET******* (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15013N
		B	D	

AFLC FORM 988 NOV. 80

* U.S. GOVERNMENT PRINTING OFFICE 1989—649-183

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15013N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89037 | PAGE 5 OF ___ PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7 PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16 PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		I.D. 1.938/1.939 IN WEAR 1.940 IN 1ST O.S. MAX 1.945 IN			
		2ND O.S. MIN 1.965 IN FOR MAX REPAIR LIMIT, MAINTIAIN MIN WALL THICKNESS OF .190 IN.			
		IN LINE WITH CROSS PIN HOLE. CROSS PIN HOLE .313/.314 IN ******HYD LINE AFT HOLES********			
		.442/.438 IN FLANGE THICKNESS .740/.745 IN *****GLAND NUT LOCK PLATE HOLES***** I.D. .312/.316 IN			
		********DOOR BRKT BOLT HOLES********* I.D. .3746/.3754 IN BUSHING ID .250/.2515			
		********ORIFICE TUBE HOLE********* I.D. 1.875/1.877 IN WEAR 1.879 IN REPAIR MAX 1.998/2.000 IN.			
		NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FMPI MUST BE PERFORMED.			
		*C/P MOVE			
QVC	032 *REQD*	100% INSPECTION OF LOWER BORE THREADS IAW T.O. 4S1-56-3 PAGE 4-3 NOTES: I & K *C/P MOVE		001 MNPGW 002 04 003 EI01	
69	035	REMOVE BUSHINGS NOT PREVIOUSLY REMOVED *C/P MOVE		001 MNPRA 002 04 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15013N
		B	D	

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AFLC FORM 958 NOV 80 PREVIOUS EDITION WILL BE USED

☆ U.S. GOVERNMENT PRINTING OFFICE: 1988—548-183

15013N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89037 | PAGE 6 OF ___ PAGES

2. JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	036	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	037	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	038	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
8	040	TRUNNION LUGS GRIND OFF CORROSION OR NICKEL FROM LUG FACE. NOT TO EXCEED 1.200/1.220 MAX REMOVAL PER SIDE .020 FACE TO FACE 9.540		001 MNPRB 002 02 003 GJ02	
		9.545 OVERALL 11.940/11.985 *C/P MOVE			
8	050	DRAG STRUT LUGS GRIND OFF CORROSION OR NICKEL FROM LUG FACE, NOT TO EXCEED CENTER LUG .996/.998 OUTSIDE LUGS .960/.980. FACE TO FACE MAX		001 MNPRB 002 02 003 GJ02	
		1.342/1.344 MAX REMOVAL PER FACE .015 *C/P MOVE			
8	060	SIDE BRACE LUG GRIND OFF CORROSION OR NICKEL FROM LUG FACE (INSIDE FACE ONLY). NOT TO EXCEED .855/.875 FACE TO FACE MAX 4.035 MAX REMOVAL PER		001 MNPRB 002 02 003 GJ02	
		FACE .015 *C/P MOVE			
8	070	[redacted] OR NICKEL FOR LUG FACE, NOT TO EXCEED 9.080/9.084 (CONTINUED)		001 MNPRB 002 02 003 GJ02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15013N
		B	D	

★ U.S. GOVERNMENT PRINTING OFFICE: 1989—640-183

15013N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89037 | 7 PAGE__OF__PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
26	080	UPPER BORE STRIP CHROME FROM UPPER BORE *C/P MOVE		001 MNPRC 002 02 003 SC02 005 XB120589	
26	090	LOWER BORE STRIP CHROME FROM LOWER BORE *C/P MOVE		001 MNPRC 002 02 003 SC02 005 XB120589	
26	100	TRUNNION LUGS GRIT BLAST LUGS TO REMOVE CORROSION 180 GRIT ALUM OXIDE *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	110	DRAG STRUT LUGS GRIT BLAST LUGS TO REMOVE CORROSION 180 GRIT ALUM OXIDE *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	120	TORQUE ARM LUGS GRIT BLAST LUGS TO REMOVE CORROSION 180 GRIT ALUM OXIDE *C/P MOVE		001 MNPRC 002 01 003 BL02	
34E	130	E & I DETERMINE ROUTE FOR LUG FACE REPAIR *C/P MOVE		001 MNPGW 002 04 003 EI01	
69	140	TRUNNION LUGS *NOTE* HAND TYPE POWER TOOLS SHALL NOT BE USED TO REPAIR DAMAGE OR CORROSION PAGE 6-4, PARA 6-72. MACH LUGS FOR BUSHINGS NOT TO EXCEED 2.820 IN *C/P MOVE		001 MNPRA 002 04 003 MH02	
69	150	DRAG STRUT LUGS MACH LUGS FOR BUSHINGS NOT TO EXCEED 1.806 IN. *C/P MOVE		001 MNPRA 002 04 003 MH02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15013N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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★ U.S. GOVERNMENT PRINTING OFFICE 1986—646-163

15013N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89037 | PAGE 8 OF PAGES

2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	160	SIDE BRACE LUGS MACH LUGS FOR BUSHINGS NOT TO EXCEED 2.185 IN. C/P MOVE		001 MNPRA 002 04 003 MH02	
69	170	TORQUE ARM LUGS 1ST REPAIR COUNTER BORE LUGS NOT TO EXCEED 2.677 IN TO A DEPTH OF 1.95/1.96 TERMINATE COUNTER BORE WITH A 0.125 RADIUS *C/P MOVE		001 MNPRA 002 04 003 BF01	
69	180	TORQUE ARM LUGS 2ND REPAIR MACH ENTIRE LENGTH OF LUGS NOT TO EXCEED 2.677 IN. *C/P MOVE		001 MNPRA 002 04 003 MH02	
69	190	UPLOCK SOCKET 1ST REPAIR MACH UPLOCK SOCKET NOT TO EXCEED 1.945 IN. *C/P MOVE		001 MNPRA 002 04 003 MH02	
69	200	UPLOCK SOCKET 2ND REPAIR MACH UPLOCK SOCKET MINIMUM 1.965 IN FOR MAX LIMIT MAINTAIN MIN WALL THICKNESS OF .190 IN. IN LINE WITH CROSS PIN HOLE. *C/P MOVE		001 MNPRA 002 04 003 MH02	
69	205	DOOR ATTACH LUG HOLES. MACHINE IAW T.O. 4S1-56-3 .0005/.0015 PRESS FIT *C/P MOVE		001 MNPRA 002 04 003 LE02	
69	210	ORIFICE TUBE HOLE MACH ORIFICE TUBE FOR BUSHING NOT TO EXCEED 1.998/2.000 IN. *C/P MOVE		001 MNPRA 002 04 003 MH02	
8	260	UPPER BORE GRIND UPPER BORE FOR CHROME PLATE NOT TO EXCEED 10.680 IN (CONTINUED)		001 MNPRB 002 01 003 GI01 005 X8022698	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT NO
DISPATCH	FUNCTIONAL CODE	A	C	15013N
		B	D	

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2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7 PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
8	270	LOWER BORE GRIND LOWER BORE FOR CHROME PLATE NOT TO EXCEED 11.040 IN. *C/P MOVE		001 MNPRB 002 01 003 GT01 005 X8022698	
				006 X8022696	
[redacted]		REWORKED AREAS DATE OUT _____ TIME OUT _____ *C/P MOVE	M	001 MNPNA 002 06 003 TE03	
		* * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *			
26B	290	BAKE 4HRS AT 350--400F WITHIN 8HRS OF ETCH DATE IN _____ TIME IN _____		001 MNPRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *	M	001 MNPNA 002 06 003 ML04	
26	305	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26 [redacted]	310	SHOTPEEN REWORKED AREAS *C/P MOVE		001 MNPRC 002 01 003 SP02	
26 [redacted]	313	PREPARE UPPER BORE FOR CHROME PLATE GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
26 [redacted]	315	PREPARE TO CHROME PLATE UPPER BORE FIXTURE/MASK/ETC MECHANIC SIGN OFF REQUIRED---------->		001 MNPRC 002 02 003 BE01 005 X8120589	
26 [redacted]	320	CHROME PLATE UPPER BORE SUFFIC- IENT TO GRIND BACK TO 10.625/10.630 TIME OUT_____DATE OUR_____ MECHANIC SIGN OFF REQUIRED---------->		001 MNPRC 002 02 003 CP01 005 X8120589	
		*C/P MOVE		008 CI010	
26B [redacted]	330	BAKE 4HRS AT 350-400F WITHIN 4HRS OF CHROME PLATE DATE IN_____TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
26 [redacted]	333	PREPARE LOWER BORE FOR CHROME PLATE GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
26 [redacted]	335	PREPARE TO CHROME PLATE LOWER BORE FIXTURE/MASK/ETC MECHANIC SIGN OFF REQUIRED---------->		001 MNPRC 002 02 003 BE01 005 X8120589	
26 [redacted]	340	CHROME PLATE LOWER BORE SUFFIC- IENT TO GRIND BACK TO 11.000/11.003 TIME OUT_____DATE OUR_____ (CONTINUED)		001 MNPRC 002 02 003 CP01 005 X8120589	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN
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2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SIC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		MECHANIC SIGN OFF REQUIRED----------> *C/P MOVE			
26B	350	BAKE 4HRS AT 350-400F WITHIN 4HRS OF CHROME DATE IN_____TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
26	353	PREPARE TRUNNION LUGS FOR NICKEL PLATE, MASK/FIXTURE/ETC *C/P MOVE		001 MNPRC 002 03 003 BE01	
26	357	PREPARE TRUNNION LUGS FOR NICKEL PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	330	TRUNNION LUGS SULFAMATE NICKEL LUG FACE SUFFICIENT TO GRIND BACK TO 1.24/1.26 IN. FACE TO FACE 9.500/9.505 IN		001 MNPRC 002 03 003 NP01 008 N0010	
		OVERALL 11.980/12.025 IN HARD NICKEL ROCKWELL C-35/C-37 DATE OUT_____TIME OUT_____ *C/P MOVE			
26B	370	BAKE 23HRS AT 350-400F WITHIN 4HRS OF NICKEL DATE IN_____TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7 PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26 [redacted]	373	PREPARE DRAG STRUT LUGS FOR NICKEL PLATE, MASK/FIXTURE/ETC *C/P MOVE		001 MNPRC 002 03 003 BE01	
26 [redacted]	377	PREPARE DRAG STRUT LUGS FOR NICKEL PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
26 [redacted]	380	DRAG STRUT LUGS SULFAMATE NICKEL LUG FACE SUFFICIENT TO GRIND BACK TO: CENTER LUG .996/.998 IN		001 MNPRC 002 03 003 NP01 008 ND020	
		OUTSIDE LUGS .99/1.01 IN FACE TO FACE 1.312/1.314 IN HARD NICKEL ROCKWELL C-35/C-39			
		DATE OUT_____ TIME OUT_____ *C/P MOVE			
26B [redacted]	390	BAKE 23HRS AT 350-400F WITHIN 4HRS OF NICKEL DATE IN_____ TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____ TIME OUT_____ *C/P MOVE			
26 [redacted]	393	PREPARE SIDE BRACE LUGS FOR NICKEL PLATE, MASK/FIXTURE/ETC *C/P MOVE		001 MNPRC 002 03 003 BE01	
26 [redacted]	397	PREPARE SIDE BRACE LUGS FOR NICKEL PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
26 [redacted]	400	SIDE BRACE LUGS SULFAMATE NICKEL LUG FACE SUFFICIENT TO GRIND BACK TO .87/.89 IN (CONTINUED)		001 MNPRC 002 03 003 NP01 008 ND030	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		FACE TO FACE 4.000/4.004 IN HARD NICKEL ROCKWELL C-35/C-39 DATE OUT_____TIME OUT_____			
		*C/P MOVE			
26B	410	BAKE 23HRS AT 350-400F WITHIN 4HRS OF NICKEL DATE IN_____TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
26	413	PREPARE TORQUE ARM LUGS FOR NICKEL PLATE, MASK/FIXTURE/ETC *C/P MOVE		001 MNPRC 002 03 003 BE01	
26	417	PREPARE TORQUE ARM LUGS FOR NICKEL PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	420	TORQUE ARM LUGS SULFAMATE NICKEL LUG FACE SUFFICIENT TO GRIND BACK TO 9.120/9.124 IN HARD NICKEL ROCKWELL C-35/C-39		001 MNPRC 002 03 003 NP01 008 ND040	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
26B	430	BAKE 23HRS AT 350-400F WITHIN 4HRS OF NICKEL DATE IN_____TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6 DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
8	440	TRUNNION LUGS FINISH GRIND LUG FACE LUG 1.24/1.26 IN FACE TO FACE 9.500/9.505 IN		001 MNPRB 002 02 003 GJ02	
		OVERALL 11.980/12.025 IN *C/P MOVE			
8	450	DRAG STRUT LUGS FINISH GRIND LUG FACE CENTER LUG .996/.998 IN OUTSIDE LUG .99/1.01 IN		001 MNPRB 002 02 003 GJ02	
		FACE TO FACE 1.312/1.314 IN *C/P MOVE			
8	460	SIDE BRACE LUGS (INSIDE FACE ONLY) FINISH GRIND LUG FACE .87/.89 IN FACE TO FACE 4.000/4.004 IN *C/P MOVE		001 MNPRB 002 02 003 GJ02	
8	470	TORQUE ARM LUGS FINISH GRIND LUG FACE 9.120/9.124 IN *C/P MOVE		001 MNPRB 002 02 003 GJ02	
8	480	UPPER BORE FINISH GRIND BORE 10.625/10.630 IN *C/P MOVE		001 MNPRB 002 01 003 GI01 005 X8022678 006 X8022696	
8	490	LOWER BORE FINISH GRIND BORE 11.000/11.003 IN *C/P MOVE		001 MNPRB 002 01 003 GI01 005 X8022698 006 X8022696	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26B	500	BAKE 4HRS AT 350-400F DATE IN_____ TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____ TIME OUT_____ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	
		* * * * * * * * * * * * * * * * * *			
26	515	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ZS01	
		* * * * * * * * * * * * * * * * * *			
26	525	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	530	CAD PLATE CLASS I TYPE II DATE OUT_____ TIME OUT_____ *C/P MOVE		001 MNPRC 002 03 003 CA01	
26B	550	BAKE 23HRS AT 350-400F WITHIN 4HRS OF CAD PLATE DATE IN_____ TIME IN_____ (CONTINUED)		001 MNPRC 002 02 003 BK01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15013N
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2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7 PART NUMBER	8 TICH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DATE OUT_____TIME OUT_____ C/P MOVE			
26	555	IRIDITE *C/P MOVE*		001 MNPRC 002 02 003 IR01	
[redacted]	165	*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED * HERE, TAKE PRODUCTION COUNT. *	M	001 MNPNA 002 06 003 ML04	
26	563	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 550 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE		001 MNPRC 002 03 003 IV01	
26	567	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNPRC 002 03 003 TA01	
69	568	MACHINE TRUNNION LUGS P/N 66C-32323-01		001 MNPRA 002 04 003 LE02	
69	570	TRUNNION LUGS MACH & INST BUSHING P/N 66C-32323-01 OR -03 PRESS FIT 0.001/0.003 FINISH DIM 2.687/2.689 IN *C/P MOVE		001 MNPRA 002 04 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATL SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69 ✓	573	MACHINE DOOR ATTACH LUG BUSHING P/N NAS7[illegible]		001 MNPRA 002 04 003 LE02	
69 ✓	575	DOOR ATTACH LUGS. INST BUSHING P/N NAS 75 4-008 .0005/.0015 PRESS FIT. *C/P MOVE		001 MNPRA 002 04 003 BE01	
69 ✓	578	MACHINE DRAG STRUT LUGS BUSHING P/N 68J29645-97A-99P		001 MNPRA 002 04 003 LE02	
69 ✓	580	DRAG STRUT LUGS INST BUSHING P/N 68J29645-97A-99P PRESS FIT 0.0007/0.0015		001 MNPRA 002 04 003 BE01	
		FINISH DIM 1.500/1.501 IN *C/P MOVE			
69 ✓	585	MACHINE SIDE BRACE LUGS BUSHING P/N 65A30315-70		001 MNPRA 002 04 003 LE02	
69 ✓	590	SIDE BRACE LUGS INST BUSH P/N 65A30315-70 PRESS FIT 0.0007 FINISH DIM 2.000/2.002 IN		001 MNPRA 002 04 003 BE01	
		*C/P MOVE			
69 ✓	598	MACHINE TORQUE ARM LUG BUSHING P/N 7127910		001 MNPRA 002 04 003 LE02	
69 ✓	[illegible]	TORQUE ARM LUGS INST BUSH P/N 7127910-02 PRESS FIT 0.001/0.003 (CONTINUED)		001 MNPRA 002 04 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		FINISH DIM 2.500/2.502 IN *C/P MOVE			
69	608	MACHINE UPLOCK SOCKET 2ND REPAIR P/N 65A30315-71		001 MNPRA 002 04 003 LE02	
69	610	UPLOCK SOCKET 2ND REPAIR IAW DWG 7729420 INST BUSH P/N 65A30315-71 FINISH DIM 1.939/1.938 IN		001 MNPRA 002 04 003 BE01	
		CROSS BOLT HOLE .313/.314 IN *C/P MOVE			
69	618	MACHINE ORIFICE TUBE HOLE BUSHING MFG BUSHING PER FIG 6-4 PAGE 6-11		001 MNPRA 002 04 003 LE02	
69	620	ORIFICE TUBE HOLE MFG BUSH & INST PER FIG 6-4 PAGE 6-11 FINISH DIM 1.875/1.877 *C/P MOVE		001 MNPRA 002 04 005 BE01	
[redacted]	640 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 95%		001 MNPGP 002 06 003 SA03	
[redacted]	650 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6 DATE COMPLETED
		MNPG9		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4S-1-182 4S1-56-3	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
KC-135 MLG		69658A 25326A 69657A 25325A
13 SERIAL NUMBER	**14 NOUN**	
	INNER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 65-1265-7 65-1265-8		NSN C/N 1620009816337 69658A 1620000842104 69657A 25325A 25326A			
		UNIT COST $4493.00			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		BLAST IAW MIL-STD-1504			
		FPI IAW MIL-STD-6866 FMPI IAW MIL-STD-1949 P/O N01561			
		CHROME IAW MIL-STD-1501			
		CADMIUM IAW MIL-STD-870 TEMP ETCH IAW MIL-STD-867 SHOTPEEN IAW MIL-S-13165 NICKEL IAW MIL-STD-868			
		BAKE IAW 4S-1-182 MAOI 74-12 IVD ALUM PLATE IAW MIL-C-83488A ALODINE IAW MIL-C-5541			
		AMS 6407 STEEL 220/240 KSI			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	INNER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. "WARNING"			
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO			
		PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	65-1265-7 65-1265-8			
	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNPGW 002 02 003 LG02 005 X8745233	
				006 X8745188	
	007 *REQD*	CHEM CLEAN *C/P MOVE		001 MNPGW 002 03 003 SL01	
	009 *REQD*	BLAST CLEAN ONLY *C/P MOVE		001 MNPGW 002 03 003 BL01	
	011 *REQD*	BAKE 4HRS AT 350-400F DATE IN_____TIME IN_____ (CONTINUED)		001 MNPGW 002 03 003 BK03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN	
	INNER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]	*REQD*	*C/P MOVE	M	001 MNPNA 002 05 003 ML04	
[redacted]	030	E & I NOTE: HAND TYPE POWER TOOLS SHALL NOT BE USED (PER PAR 6-7C, PG 6-4)		001 MNPGW 002 04 003 EI01	
		O.D. 9.993/9.996 WEAR 9.989 IN REPAIR MIN 9.974 IN.			
		I.D. 9.450/9.490 WEAR 9.492 IN. SULKHEAD SEAL 9.375/9.378 IN			
		******TORQUE ARM LUGS****** 2.500/2.502 WEAR 2.504 IN. REPAIR MAX 2.677 IN.			
		FACE TO FACE 4.360/4.363 IN. OVERALL 9.124/9.120 IN REPAIR MIN 9.080/9.084 IN			
		LUG WIDTH 1.88 IN REPAIR MIN 1.86 IN. ******PIVOT LUG******			
		BASE METAL 3.7500/3.7515 IN. 3.775 MAX BUSH I.D. 3.376/3.378 IN. WEAR 3.385 IN.			
		BUSHING FACE/FACE 10.000/10.007 FACE TO FACE 10.250/10.255 IN. LUG WIDTH 1.685/1.690 IN. (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15014N
		B	D	

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15014N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89037 PAGE 4 OF 4 PAGES

2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 *OPTIONAL
13 SERIAL NUMBER	14 NOUN	
	INNER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		NOTE: NO O.S. AUTHORIZED PER NOTE 1 PAGE 5-10, FIG 5-2. ***BRAKE EQUALIZER ROD ATT LUG* BASE METAL I.D. 1.750/1.751 IN.			
		BUSH I.D. 1.625/1.626 IN. WEAR 1.629 IN. REPAIR MAX 1.6710 IN. LUG WIDTH 1.120/1.25 IN.			
		******SNUBBER ATT LUG****** BASE METAL .8115/.8125 IN.			
		BUSH I.D. .625/.6265 WEAR .628 IN. REPAIR MAX .9325 IN. LUG WIDTH 1.120/1.125 IN.			
		NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FMPI MUST BE PERFORMED.			
		*C/P MOVE			
26	035	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	040	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	045	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
26	050	STRIP CHROME CYLINDER O.D. *C/P MOVE		001 MNPRC 002 02 003 SC02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15014N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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15014N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89037 | PAGE 5 OF PAGES

2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13 SERIAL NUMBER	14 NOUN
	INNER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	060	STRIP CHROME CYLINDER I.D. *C/P MOVE		001 MNP 002 02 003 SC02	RC
26	070	GRIT BLAST TORQUE ARM LUGS (FACE) TO REMOVE CORROSION 180 GRIT ALUM OXIDE *C/P MOVE		001 MNP 002 01 003 BL02	RC
34E	080	E & I DETERMINE ROUTE FOR LUG FACE REPAIR *C/P MOVE ***NOTE: HAND TYPE POWER TOOLS		001 MNP 002 04 003 EI01	GW
		SHALL NOT BE USED PER PAGE 6-4, PARA 6-72.			
69	105	MACH PIVOT LUGS. FOR BUSHINGS NOT TO EXCEED 3.775 32 RMS *C/P MOVE		001 MNP 002 04 003 MH02	RA
69	110	MACH TORQUE ARM LUGS. FOR BUSHINGS NOT TO EXCEED 2..77 IN. 32 RMS *C/P MOVE		001 MNP 002 04 003 MH02	RA
69	120	MACH BRAKE EQUALIZER ROD ATT LUG FOR BUSHINGS NOT TO EXCEED 1.8710 IN. 32 RMS *C/P MOVE		001 MNP 002 04 003 MH02	RA
69	130	MACH SNUBBER ATT LUG FOR BUSHING NOT TO EXCEED .9325 IN. 32 RMS *C/P MOVE		001 MNP 002 04 003 MH02	RA
8	140	GRIND TORQUE ARM LUG (FACE) LUG FACE FOR NICKEL PLATE NOT TO EXCEED 1.86 IN. MAX REMOVAL PER FACE .020 IN.		001 MNP 002 02 003 GS03	RB
		OVERALL REPAIR 9.080/9.084 IN. 32 RMS *C/P MOVE			

21 FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15014N
		B	D	

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15014N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89037 | PAGE 6 OF PAGES

2 JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	INNER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
8	150	GRIND CYLINDER O.D. FOR CHROME NOT TO EXCEED 9.974 IN. 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GE08	
8	160	GRIND CYL. I.D.(BULKHEAD SEAL AREA) NOT TO EXCEED MIN. WALL THICKNESS OF .283 IN. FIG 6-7, PAGE 6-14, AREA F 32 RMS *C/P MOVE		001 MNPRB 002 02 003 GI04	
[redacted]		DATE IN---------- TIME IN---------- DATE OUT---------- TIME OUT---------- *C/P MOVE*	M	001 MNPNA 002 06 003 TE03	
		* * * * * * * *N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED * HERE, TAKE PRODUCTION COUNT. *			
26B	180	BAKE 4HRS AT 350-400F WITHIN 8HRS OF ETCH DATE IN_____ TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____ TIME OUT_____ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *	M	001 MNPNA 002 06 003 ML04	
26	195	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	200	SHOTPEEN REWORKED AREAS *C/P MOVE		001 MNPRC 002 01 003 SP02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15014N
		B	D	

★ U.S. GOVERNMENT PRINTING OFFICE 1988—548-163

15014N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89037 PAGE 7 OF PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 'OPTIONAL
13 SERIAL NUMBER	14 NOUN	
	INNER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	205	PREPARE TO CHROME PLATE CYLINDER O.D. FIXTURE/MASK/ETC MECHANIC SIGN OFF REQUIRED---------->		001 MNPRC 002 02 003 BE01 005 X8120899	
26	210	CHROME PLATE CYLINDER O.D. SUFF- ICIENT TO GRIND BACK TO 9.993/9.996 TIME OUT_____DATE OUR_____ MECHANIC SIGN OFF REQUIRED---------->		001 MNPRC 002 02 003 CP01 005 X8120899	
		*C/P MOVE		008 CO010	
26B	220	BAKE 23HRS AT 350/400 WITHIN 4HRS OF CHROME DATE IN_____TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
26	223	IF CHROME PLATE REQUIRED PREPARE TO CHROME PLATE CYLINDER I.D. (BULKHEAD SEAL AREA) MASK/FIXTURE/ETC		001 MNPRC 002 02 003 BE01 005 X8120873	
		MECHANIC SIGN OFF REQUIRED---------->			
26	225	CHROME PLATE CYLINDER I.D. (BULKHEAD SEAL AREA) SUFFICIENT TO GRIND BACK TO 9.375/9.378 IAW 4S1-56-3 * NOTE ON PAGE 6-8*		001 MNPRC 002 02 003 CP01 005 X8120873	
		TIME OUT_____DATE OUR_____ MECHANIC SIGN OFF REQUIRED----------> *C/P MOVE		008 CI010	
26	226	PREPARE FOR NICKEL PLATE. MASK/FIXTURE/ETC *C/P MOVE		001 MNPRC 002 03 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15014N
		B	D	

AFLC FORM 958 NOV 90 PREVIOUS EDITION WILL BE USED

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15014N **WORK CONTROL DOCUMENT (MEDS)** | 1. DATE 89037 | PAGE 6 OF 6 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	INNER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	228	PREPARE FOR NICKEL PLATE, GRIT BLAST ALL AREAS TO BE NICKEL PLATED *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	230	IF NICKEL PLATE REQUIRED NICKEL PLATE CYLINDER I.D. (BULKHEAD SEAL AREA) SUFFICIENT TO GRIND BACK TO 9.375/9.378		001 MNPRC 002 03 003 NP01 008 NI010	
		IAW 4S1-56-3 * NOTE ON PAGE 6-8 * DATE OUT_____ TIME OUT_____ *C/P MOVE			
26	235	NICKEL PLATE TORQUE ARM LUG FACES SUFFICIENT TO GRIND TO 9.124/9120 IAW 4S1-56-3 DATE OUT_____ TIME OUT_____		001 MNPRC 002 03 003 NP01 008 NI010	
		*C/P MOVE			
26B	245	BAKE 23HRS AT 350-400F WITHIN 4HRS OF NICKEL PLATE OR CHROME PLATE DATE IN_____ TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____ TIME OUT_____ *C/P MOVE			
8	250	FINISH GRIND TORQUE ARM LUG FACE OVERALL 9.124/9.120 IN. LUG WIDTH 1.88 IN 32 RMS *C/P MOVE		001 MNPRB 002 02 003 GS03	
8	260	FINISH GRIND CYLINDER I.D. 9.993/9.996 IN. 32 RMS *C/P MOVE		001 MNPRB 002 03 003 GE08	
8	270	CYLINDER I.D. (BULKHEAD SEAL AREA) FINISH GRIND SEAL AREA 9.375/9.378 IN. 32 RMS *C/P MOVE		001 MNPRB 002 02 003 GI04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15014N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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15014N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89037 | PAGE 9 OF PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	INNER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26B [redacted]	280	BAKE 4HRS AT 350-400F DATE IN_____TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *	M	001 MNPNA 002 06 003 ZS01	
26 [redacted]	305	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		001 MNPRC 002 01 003 BL02	
26 [redacted]	310	CAD PLATE CLASS I TYPE II I.A.W T.O. 4S1-56-3 PAGE 6-2 FIG 6-1 DATE OUT_____TIME OUT_____ *C/P MOVE		001 MNPRC 002 03 003 CA01	
26B [redacted]	330	BAKE 23HRS AT 350-400F WITHIN 4HRS OF CAD DATE IN_____TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
26 [redacted]	332	IRIDITE *C/P MOVE*		001 MNPRC 002 02 003 IR01	
[redacted]	.65	*C/P MOVE * * * * * * N O T E * * * * * * * (CONTINUED)	M	001 MNPNA 002 06 003 ML04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15014N
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* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-165

15014N **WORK CONTROL DOCUMENT (MEDS)**

2. JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	INNER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *			
26	337	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION---220 OR 225 MUST BE ACCOMPLISHED IF PRIOR PLAING REWORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE		001 MNPRC 002 03 003 IV01	
26	338	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNPRC 002 03 003 TA01	
69	339	MACHINE TORQUE ARM LUG BUSHINGS P/N530995-01		001 MNPRA 002 04 003 LE02	
69	340	INSTALL TORQUE ARM LUGS BUSH P/N 7530995-01 FIN DIM 2.50/2.502 IN. .001/.003 PRESS FIT 32 RMS *C/P MOVE		001 MNPRA 002 04 003 BE01	
69	348	MACHINE PIVOT LUG BUSHINGS P/N 66-10615-1 P/N 8121215-0/S		001 MNPRA 002 04 003 LE02	
69	350	INSTALL PIVOT LUG BUSHINGS P/N 66-10615-1 3.376/3.378 P/N 8121215 0/S PRESS FIT .001/.003 32 RMS *C/P MOVE		001 MNPRA 002 04 003 BE01	
69	358	MACHINE BRAKE EQUALIZER ROD ATTACH LUGS BUSHING P/N 67C30360		001 MNPRA 002 04 003 LE02	
69	360	INSTALL BRAKE EQUALIZER ROD ATTACH LUGS BUSH P/N 67C30360 FINISH DIM 1.625/1.626 IN. 32 RMS (CONTINUED)		001 MNPRA 002 04 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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☆ U.S. GOVERNMENT PRINTING OFFICE: 1966—646-183

15014N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89037 | PAGE [redacted] OF [redacted] PAGES

2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 'OPTIONAL'
13. SERIAL NUMBER	14 NOUN	
	INNER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		.001/.002 PRESS FIT *C/P MOVE			
69 ✓	368	MACHINE SNUBBER ATTACH LUGS BUSHING P/N 67C30359-3 P/N 67C30359-1		001 MNPRA 002 04 003 LE02	
69 ✓	370	INSTALL SNUBBER ATT LUGS BUSH P/N 67C30359-3 & 67C30359-1 FINISH DIM .6250/.6265 IN. 32 RMS		001 MNPRA 002 04 003 BE01	
		.0007/.0013 PRESS FIT *C/P MOVE			
[redacted]	380 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 06 003 SA03	
[redacted]	390 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
		MNPG9		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4S1-56-3	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
KC-135 MLG		69658A 69657A 25326A 25325A
13. SERIAL NUMBER	**14. NOUN**	
	BEARING (LOWER)	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 7653528-01		NSN 3120010403938 C/N 69658A, 69657A, 25325A, 25326A			
		****UNIT COST $ 155.03**** GOVERNING DIRECTIVES: AFLCR 66-51, MANOI 66-3 CADMIUM PLATE IAW MIL-STD-870 FPI IAW MIL-STD-6866 IVD ALUM PLATE IAW MIL-C-83488A ALODINE IAW MIL-C-5541 **********			
		ALUM NICKEL BRONZE AMS 4640 AMS 4880 **********			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		"WARNING" MANY OF THE FOLLOWING REPAIR (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15015N
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2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	BEARING (LOWER)

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND			
		PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN			
		COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	7653528-01			
341	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNPGW 002 02 003 LG02 005 X8745233 006 X8745188	
341	006 *REQD*	DEGREASE ONLY *C/P MOVE		001 MNPGW 002 02 003 DG02	
[redacted]	 *REQD*	*C/P MOVE	M	001 MNPNA 002 05 003 ZY05	
	020 *REQD*	E & I I.D. 10.003/10.006 WEAR 10.008 IN.		001 MNPGW 002 04 003 EI01	
		O.D. 10.994/10.997 WEAR 10.992 IN *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15015N
		B	D	

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2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN	
	BEARING (LOWER)	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	028	MODIFY IAW DWG 7653528 P/N 89-11399		001 MNPRA 002 04 003 LE02	
69	030	REIDENTIFY 7653528-01 *C/P MOVE		001 MNPRA 002 04 003 BE01	
26	033	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	037	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	038	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE		001 MNPRC 002 01 003 BL04	
26	040	CAD PLATE CLASS II TYPE I *C/P MOVE		001 MNPRC 002 03 003 CA01	
26	042	IRIDITE *C.P MOVE		001 MNPRC 002 02 003 IR01	
26	044	VAC IVD ALUM PLATE CLASS 2 TYPE II *C/P MOVE		001 MNPRC 002 03 003 IV01	
26	046	ALODINE IVD ALUM PLATE CLASS IA *C/P MOVE		001 MNPRC 002 03 003 TA01	
[redacted]	050 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 95[illegible]		001 MNPGP 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15015N
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15015N WORK CONTROL DOCUMENT (MEDS)

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL/DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	BEARING (LOWER)

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	060 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNFGP 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15015N
		B	D	

AFLC FORM 958 NOV 80 PREVIOUS EDITION WILL BE USED

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2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC MNPG9	5. DATE SCHED.	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4S-1-182 4S1-56-3	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
KC-135 MLG		69658A 69657A
13. SERIAL NUMBER	**14. NOUN**	
	PIN, METERING	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 65-5735		NSN 1620007390166 C/N 69658A 69657A 25325A 25326A			
		****UNIT COST $ 433.36**** GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		FPI IAW MIL-STD-6866 ANODIZE IAW MIL-A-8625 **********A L U M I N U M********** **			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		"WARNING" MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO (CONTINUED)			

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				15016N
		B	D	

AFLC FORM 958 NOV 82

15016N WORK CONTROL DOCUMENT (MEDS) | 1 DATE 89037 | PAGE 02 OF PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/ACC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	PIN, METERING

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	65-5735			
[redacted]	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNFGW 002 02 003 LG02 005 X8745233 006 X8745188	
[redacted]D	006 *REQD*	DEGREASE ONLY *C/P MOVE		001 MNFGW 002 02 003 DG02	
[redacted]	 *REQD*	*C/P MOVE	M	001 MNFNA 002 05 003 ZY05	
[redacted]	020 *REQD*	E & I SEAL GROOVE 8.926/8.930 IN. *C/P MOVE		001 MNFGW 002 04 003 EI01	
26	030	STRIP ANODIZE *C/P MOVE		001 MNFRC 002 03 003 AN04	
[redacted]		*C/P MOVE (CONTINUED)	M	001 MNFNA 002 06 003 ZA02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENTATION
DISPATCH	FUNCTIONAL CODE	A	C	15016N
		B	D	

15016N WORK CONTROL DOCUMENT (MEDS)

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	PIN, METERING

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		* * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * * * * * * * * * * * * * * * * * * *			
26	040	ANODIZE *C/P MOVE		001 MNPRC 002 03 003 AS03	
	060 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 06 003 SA03	
	070 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/ON
DISPATCH	FUNCTIONAL CODE	A	C	15016N
		B	D	

15017N WORK CONTROL DOCUMENT (MEDS) | 1 DATE 89037 | PAGE 1 OF PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
		MNPG9		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4S-1-182 4S1-56-3	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
KC-135 MLG		69658A 25325A 69657A 25326A
13. SERIAL NUMBER	**14 NOUN**	
	PISTON ROD	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 7531269-30		NSN 1620010273442 C/N 69658A 25325A 25326A 69657A			
		****UNIT COST $1772.00**** GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		FPI IAW MIL-STD-6866 **********ALUMINUM 7075-T6**********			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		"WARNING" MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15017N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

15J17N WORK CONTROL DOCUMENT (MEDS) | 1. DATE 89037 | PAGE 2 OF # PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL/DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN	
	PISTON ROD	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	7531269-30			
[redacted]	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNPGW 002 02 003 LG02 005 X8745233 006 X8745188	
[redacted]	006 *REQD*	DEGREASE ONLY *C/P MOVE		001 MNPGW 002 02 003 DG02	
[redacted]	[redacted] *REQD*	*C/P MOVE	M	001 MNPNA 002 05 003 ZY05	
[redacted]	020 *REQD*	E & I *C/P MOVE		001 MNPGW 002 04 003 EI01	
J	[redacted] *REQD*	[redacted] FIG 6-5 PAGE 6-12 *C/P MOVE		001 MNPRA 002 04 003 BE01	
[redacted]	030 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 950		001 MNPQP 002 06 003 SA03	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				15017N
		B	D	

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AFLC FORM 988 NOV. 80 PREVIOUS EDITION WILL BE USED

15017N **WORK CONTROL DOCUMENT (MEDS)**

1. DATE 89037 | PAGE 3 OF 3 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN	
	PISTON ROD	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	040	FINAL PRODUCT VISUAL INSPECTION		001 MNFOP	
	REQD	*C/P MOVE		002 06	
				003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	15017N
		B	D	

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KC-135 MLG

7A STRUT KC135 MLG L/H RCC MNPRA 4S1-56-3 038-9102 83083

OPER	TECH	S	S	U	F	PF	A/R	REV		OCC	DESCRIPTION		BASE	PFD	STD	A
	EP	D	T	K	#R	A	FA	SUPPORT ELEMENT		FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C
RA013	S	E	JA	EA	1		J	83083		.95	PERCENT ENGR 89.5	MACHINE OUTER CYLINDER 303E	9.13		8.67	
0001			JA	01	00					.00		PART NUMBER/NSN	.000	.000	.000	0
0010											65-5763-17	1620009274739				
0020											65-5763-18	1620009592078				
0030											50-9712-32	1620007871750				
0040											50-9712-31	1620007871749				
0035			JA	01	15					.25		REMOVE BUSHINGS	.296	.011	.085	1
0010	E					RBW-SU-G1				1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
0020	E					RLG-RS-K1				1.00	REM BUSHING (1ST OR SINGLE)		.01099		.012	
0030	E					RLG-RS-K2				1.00	REM BUSHING (2ND OR ADDL)		.00413		.004	
0040	E					RJP-PW-F1				1.00	SIGN OFF WORK CONTROL DOC		.00601		.006	
0140			JA	01	15					.35		MACH TRUN LUGS	1.475	.077	.594	7
0010	E					RML-SU-V3				.33	S/U VERT MIL BORE FXTR HOISTPRO RATE		1.03687		.393	
0020	E					RML-AL-CC				1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0030	E					RML-BD-EB				2.00	BORE HOLE 3 X 1 GROUP 4	2 HOLES	.48623		1.118	
0040	E					RTL-MM-M2				6.00	MIKE TEL GAGE ID MIKE CALPR	6 TIMES	.00966		.066	
0050	E					RBW-DB-K1				1.00	DEBURR 3 INCH HOLE W/KNIFE		.00534		.006	
0060	E					RBW-DB-K2				3.00	DEBURR ADDTNL 3 INCH HOLE		.00502		.017	
0070	E					RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0150			JA	01	15					.32		MACH DRAG STRUT LUGS	1.701	.082	.626	7
0010	E					RML-SU-V3				.30	S/U VERT MIL BORE FXTR HOISTPRO RATE		1.03687		.357	
0020	E					RML-AL-CC				1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0030	E					RTL-MM-M2				9.00	MIKE TEL GAGE ID MIKE CALPR	9 TIMES	.00966		.099	
040	E					RML-BD-CB				3.00	BORE HOLE 2 X 1 GROUP 4	3 HOLES	.40027		1.380	
0050	E					RBW-DB-K1				1.00	DEBURR 3 INCH HOLE W/KNIFE		.00534		.006	
0060	E					RBW-DB-K2				3.00	DEBURR ADDTNL 3 INCH HOLE		.00502		.017	
0070	E					RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0160			JA	01	15					.38		MACH SIDE BRACE LUGS	1.303	.074	.570	6
0010	E					RML-SU-V3				.33	S/U VERT MIL BORE FXTR HOISTPRO RATE		1.03687		.393	
0020	E					RML-AL-CC				1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0030	E					RML-BD-CB				2.00	BORE HOLE 2 X 1 GROUP 4	2 HOLES	.40027		.920	
0040	E					RTL-MM-M2				6.00	MIKE TEL GAGE ID MIKE CALPR	6 TIMES	.00966		.066	
0050	E					RBW-DB-K1				1.00	DEBURR 3 INCH HOLE W/KNIFE		.00534		.006	
0060	E					RBW-DB-K2				3.00	DEBURR ADDTNL 3 INCH HOLE		.00502		.017	
0070	E					RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0170			JA	01	15					.25		MACH TOR ARM LUGS 1ST	1.820	.068	.523	6
0010	E					RML-SU-V3				.33	S/U VERT MIL BORE FXTR HOISTPRO RATE		1.03687		.393	
0020	E					RML-AL-CC				1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0030	E					RML-BD-DB				2.00	BORE HOLE 2.5 X 2 GROUP 4	2 HOLES	.65881		1.515	
0040	E					RTL-MM-M2				6.00	MIKE TEL GAGE ID MIKE CALPR	6 TIMES	.00966		.066	
0050	E					KIT-MC-B3				6.00	GAGE DIMENSION W/SCALE/RULE	6 TIMES	.00161		.011	
0060	E					RBW-DB-K1				1.00	DEBURR 3 INCH HOLE W/KNIFE		.00534		.006	
0070	E					RBW-DB-K1				1.00	DEBURR 3 INCH HOLE W/KNIFE		.00534		.006	
0080	E					RJP-PW-R1				1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0180			JA	01	15					.25		MACH TOR ARM LUGS 2ND	1.810	.068	.521	6
0010	E					RML-SU-V3				.33	S/U VERT MIL BORE FXTR HOISTPRO RATE		1.03687		.393	
0020	E					RML-AL-CC				1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0030	E					RML-BD-DB				2.00	BORE HOLE 2.5 X 2 GROUP 4	2 LUGS	.65881		1.515	
040	E					RTL-MM-M2				6.00	MIKE TEL GAGE ID MIKE CALPR	6 TIMES	.00966		.066	
50	E					RBW-DB-K1				1.00	DEBURR 3 INCH HOLE W/KNIFE		.00534		.006	
0060	E					RBW-DB-K2				1.00	DEBURR ADDTNL 3 INCH HOLE		.00502		.005	

0070	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
[illegible]		JA	01	15	.06		MACH UPLOCK SOC 1ST	.849	.008	.059	1
0010	E		RML-SU-V3	.33	S/U VERT MIL BORE FXTR HOISTPRO RATE			1.03687		.393	
0020	E		RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS			.07261		.083	
0030	E		RML-BD-CB	1.00	BORE HOLE 2 X 1 GROUP 4			.40027		.460	
0040	E		RTL-MM-M2	3.00	MIKE TEL GAGE ID MIKE CALPR 3 TIMES			.00966		.033	
0050	E		RBW-DB-K1	1.00	DEBURR 3 INCH HOLE W/KNIFE			.00534		.006	
0200		JA	01	15	.08		MACH UPLOCK SOCET 2ND	1.554	.019	.143	2
0010	E		RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST			1.03687		1.192	
0020	E		RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS			.07261		.083	
0030	E		RML-BD-CB	1.00	BORE HOLE 2 X 1 GROUP 4			.40027		.460	
0040	E		RTL-MM-M2	3.00	MIKE TEL GAGE ID MIKE CALPR			.00966		.033	
0050	E		RBW-DB-K1	1.00	DEBURR 3 INCH HOLE W/KNIFE			.00534		.006	
0060	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0205		JA	01	15	.22		MACH DOOR ATT LUG HOLES	.680	.022	.172	2
0010	E		RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE			.49962		.574	
0020	E		RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.011	
0025	E		ZPO-BP-B1	2.00	BUTTERFLY POLISH BUSHING I.D2 LUGS			.00591		.013	
0030	E		RLA-BO-DE	1.00	BORE HOLE 1 1/2 - 2 DIA 1 DP			.14959		.172	
0040	E		KTL-DB-A2	1.00	DEBURR HOLE ADDL BOTH SIDES			.00294		.003	
0050	E		RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC			.00601		.006	
0210		JA	01	15	.50		MACH ORIFICE TUBE HOLE	1.672	.125	.962	11
0010	N				.50		SET UP RMLSUV3	1.15000		.661	
0020	N				1.00		LOAD PART RMLHPCD	.20000		.230	
0030	N				1.00		ALIGN HOLE RMLALCC	.08000		.092	
0040	N				1.00		ALIGN AXIS RMLALCA	.07000		.080	
0050	N				1.00		BORE ID RMLBDCE	.73100		.840	
0060	E		RBW-DB-K1	2.00	DEBURR 3 INCH HOLE W/KNIFE	2 PLACES		.00534		.012	
0070	E		RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC			.00601		.006	
[illegible]		JA	01	15	.90		MACH TRUN LUG BUSHING	.438	.059	.454	5
0010	E		RLA-SU-S3	.20	SET UP SMALL MEDIUM LATHE	PRO RATE		.49962		.114	
0020	E		RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.011	
0030	E		RLA-BO-EE	1.00	BORE HOLE 2 - 2 1/2 DIA 1 DP			.17205		.197	
0040	E		KML-TD-FA	1.00	DIA 2.00-3.00 REMOVE (.033			.14659		.168	
0050	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0570		JA	01	15	.90		INST TRUN LUG BUSH	.350	.047	.362	4
0050	E		RBW-BU-S1	.20	SET UP TO REBUSH BOSSES	PRO RATE		.18669		.042	
0055	E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES			.23835		.274	
0060	E		KTL-RM-B2	1.00	REAM BUSHING W ADJUST LEMPCO			.06442		.074	
0070	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0573		JA	01	15	.95		MACHINE DOOR ATTACH LUGS	.265	.038	.290	3
0010	E		RLA-SU-S3	.20	SET UP SMALL MEDIUM LATHE			.49962		.114	
0015	E		RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.011	
0020	E		RLA-BO-DE	1.00	BORE HOLE 1 1/2 - 2 DIA 1 DP			.14959		.172	
0030	E		RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC			.00601		.006	
0575		JA	01	15	.95		INST DOOR ATT LUGS	.265	.038	.290	3
0010	E		RBW-BU-S1	.20	SET UP TO REBUSH BOSSES	PRO RATE		.18669		.042	
0020	E		RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES			.22231		.255	
0030	E		RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC			.00601		.006	
0578		JA	01	15	.90		MACHINE DRAG STRUT BUSHING	.441	.060	.457	5
0010	E		RLA-SU-S3	.20	SET UP SMALL MEDIUM LATHE	PRO RATE		.49962		.114	
0020	E		RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.011	
0030	E		RLA-BO-DE	1.00	BORE HOLE 1 1/2 - 2 DIA 1 DP			.14959		.172	
0040	E		KML-TD-EC	1.00	DIA 1.50-2.00 REM .033-.250			.17225		.198	
0050	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
[illegible]		JA	01	15	.90		INST DRAG STRUT BUSH	.269	.036	.279	3

0050 E		RBW-BU-S1	.20	SET UP TO REBUSH BOSSES	PRO RATE		.18669		.042	
0060 E		RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES			.22231		.255	
070 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
	JA 01	15	.95		MACHIN SIDE BRACE BUSHING		.464	.066	.507	6
0010 E		RLA-SU-S3	.20	SET UP SMALL MEDIUM LATHE	PRO RATE		.49962		.114	
0020 E		RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.011	
0030 E		RLA-BO-EE	1.00	BORE HOLE 2 - 2 1/2 DIA 1 DP			.17205		.197	
0040 E		KML-TD-EC	1.00	DIA 1.50-2.00 REM .033-.250			.17225		.198	
0050 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0590	JA 01	15	.95		INST SIDE BRACE BUSH		.483	.069	.528	6
0040 E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES			.18669		.214	
0050 E		RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES			.22231		.255	
0060 E		KTL-RM-B2	1.00	REAM BUSHING W ADJUST LEMPCO			.06442		.074	
0070 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0598	JA 01	15	.86		MACH BUSH TORQ ARM LUG		.375	.048	.372	4
0010 E		RLA-SU-S3	.20	SET UP SMALL MEDIUM LATHE	PRO RATE		.49962		.114	
0020 E		RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.011	
0030 E		RLA-BO-FE	1.00	BORE HOLE 2 1/2 - 3 DIA 1 DP			.25592		.294	
0070 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0600	JA 01	15	.86		INST TOR ARM BUSH		.395	.051	.391	4
0070 E		RBW-BU-S1	.20	SET UP TO REBUSH BOSSES	PRO RATE		.18669		.042	
0080 E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES			.23835		.274	
0090 E		KML-TD-FD	1.00	DIA 3.00 REM .250 ADD INCH			.10968		.126	
0100 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0608	JA 01	15	.92		MACH UPLOCK SOCKET 2ND REP		.266	.037	.282	3
0010 E		RLA-SU-S3	.20	SET UP SMALL MEDIUM LATHE	PRO RATE		.49962		.114	
0020 E		RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.011	
0030 E		KML-TD-FA	1.00	DIA 2.00-3.00 REMOVE (.033			.14659		.168	
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
..10	JA 01	15	.92		INSTALL UPLOCK SOCKET BUSH		.207	.029	.220	2
0040 E		RBW-BU-S1	.50	SET UP TO REBUSH BOSSES	PRO RATE		.18669		.107	
0050 E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING			.02062		.023	
0060 E		RBW-BU-R3	1.00	REAM BUSHING SET W/STEP RMR			.08361		.096	
0070 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0618	JA 01	15	.75		MACHINE ORIFICE TUBE BUSHING		.222	.025	.192	2
0010 E		RLA-SU-S3	.20	SET UP SMALL MEDIUM LATHE	PRO RATE		.49962		.114	
0020 E		KML-TD-EA	1.00	DIA 1.50-2.00 REM (.033			.11664		.134	
0060 E		RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC			.00601		.006	
0620	JA 01	15	.75		INST ORIFICE TUBE BUSH		.296	.033	.256	3
0030 E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES			.18669		.214	
0040 E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING			.02062		.023	
0050 E		RBW-BU-R3	1.00	REAM BUSHING SET W/STEP RMR			.08361		.096	
0060 E		RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC			.00601		.006	
0990	JA 01	15	.01		LABOR STD HISTORY		.000	.000	.000	0
0010				INITIAL INPUT MARCH 1983						
0020				20APR85 DOWNGRADE TO N STD-TIME WAS 7.91HRS						
0990				MANUEL CLINTON BENTLEY MRP II 7-3255						

TO INTERROGATE LABOR STANDARDS, INPUT

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   PRD MROP NR
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OPER SUB STEP	TECH D	S T L	S W R K	F A C	PF FA DC	A/R SUPPORT ELEMENT	REV OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
RA014	S	E	JA	EA	1	J 83083	.80	PERCENT ENGR 89.5	MACHINE PISTON KC135M 303E	7.80		6.24		
0001			JA	01	00		.00		PART NUMBER/NSN	.000	.000	.000		0
0010								65-1265-7	1620009816337					
0020								65-1265-8	1620000842104					
0105			JA	01	15		.75		MACH PIVOT LUGS	1.283	.144	1.107		14
0010	E					RML-SU-V3	.33	S/U VERT MIL BORE FXTR HOISTPRO RATE		1.03687		.393		
0020	E					RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0030	E					RML-BD-CB	2.00	BORE HOLE 2 X 1 GROUP 4	2 HOLES	.40027		.920		
0040	E					RTL-MM-M2	6.00	MIKE TEL GAGE ID MIKE CALPR	6 TIMES	.00966		.066		
0050	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0110			JA	01	15		.50		MACH TORQUE ARM LUGS	1.920	.144	1.104		14
0010	E					RML-SU-V3	.33	S/U VERT MIL BORE FXTR HOISTPRO RATE		1.03687		.393		
0020	E					RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0030	N						2.00		BORE 2 PLCS RMLBDDD	.70900		1.630		
0040	E					RTL-MM-M2	6.00	MIKE TEL GAGE ID MIKE CALPR	6 TIMES	.00966		.066		
0050	E					KIT-MC-B3	6.00	GAGE DIMENSION W/SCALE/RULE	6 TIMES	.00161		.011		
0060	E					RBW-DB-K1	1.00	DEBURR 3 INCH HOLE W/KNIFE		.00534		.006		
0070	E					RBW-DB-K2	1.00	DEBURR ADDTNL 3 INCH HOLE		.00502		.005		
0080	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
			JA	01	15		.75		MACH BRAKE EQUAL ROD	1.304	.147	1.125		14
0010	E					RML-SU-V3	.33	S/U VERT MIL BORE FXTR HOISTPRO RATE		1.03687		.393		
0020	E					RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0030	E					RML-BD-CB	2.00	BORE HOLE 2 X 1 GROUP 4	2 HOLES	.40027		.920		
0040	E					RTL-MM-M2	6.00	MIKE TEL GAGE ID MIKE CALPR	6 TIMES	.00966		.066		
0050	E					RBW-DB-K1	4.00	DEBURR 3 INCH HOLE W/KNIFE	4 PLACES	.00534		.024		
0060	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0130			JA	01	15		.35		MACH SNUBBER ATT LUG	.447	.023	.180		2
0010	E					RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316		
0020	E					RBW-BU-R2	2.00	REAM WITH LEMPCO REAMER	2 LUGS	.07337		.168		
0030	E					ZPO-BP-B1	2.00	BUTTERFLY POLISH BUSHING I.D	2 LUGS	.00591		.013		
0040	E					KTL-DB-A1	1.00	DEBURR HOLE FIRST BOTH SIDES		.00449		.005		
0050	E					KTL-DB-A2	1.00	DEBURR HOLE ADDL BOTH SIDES		.00294		.003		
0060	E					RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC		.00601		.006		
0339			JA	01	15		.80		MACH BUSH TORQUE ARM LUG	1.137	.137	1.047		13
0010	E					RLA-SU-S3	.20	SET UP SMALL MEDIUM LATHE	PRO RATE	.49962		.114		
0020	E					RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011		
0030	E					RLA-BO-FE	1.00	BORE HOLE 2 1/2 - 3 DIA 1 DP		.25592		.294		
0040	E					RLA-BO-FF	1.00	BORE HOLE 2.5-3 DIA. ADD IN		.13721		.157		
0050	E					KNL-TD-FC	1.00	DIA 2.00-3.00 REM .033-.250		.21212		.243		
0060	E					KNL-TD-FD	1.00	DIA 3.00 REM .250 ADD INCH		.10968		.126		
0065	E					KTL-RM-B2	1.00	REAM BUSHING W ADJUST LEMPCO		.06442		.074		
0080	E					RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES		.23835		.274		
0090	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0340			JA	01	15		.80		INST TOR ARM LUG BUSH	.350	.042	.322		4
0070	E					RBW-BU-S1	.20	SET UP TO REBUSH BOSSES	PRO RATE	.18669		.042		
080	E					RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES		.23835		.274		
085	E					KTL-RM-B2	1.00	REAM BUSHING W ADJUST LEMPCO		.06442		.074		
0090	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0348			JA	01	15		.95		MACH PIVOT LUG BUSHING	.585	.083	.639		8

0010	E		RLA-SU-S3	.20	SET UP SMALL MEDIUM LATHE	PRO RATE		.49962		.114	
0020	E		RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.011	
0030	E		RLA-BO-EE	1.00	BORE HOLE 2 - 2 1/2 DIA 1 DP			.17205		.197	
0040	E		KML-TD-FA	2.00	DIA 2.00-3.00 REMOVE (.033	2 SETS		.14659		.337	
0045	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0350		JA 01	15	.95		INST PIVOT LUG BUSH		.561	.080	.613	8
0050	E		RBW-BU-S1	.40	SET UP TO REBUSH BOSSES	PRO RATE		.18669		.085	
0060	E		RBW-BU-B1	2.00	REBUSH A SET OF 2 BOSSES	2 SETS		.23835		.548	
0070	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0358		JA 01	15	.75		MACH BRAKE EQUAL ROD ATT LUG		.551	.062	.476	6
0010	E		RLA-SU-S3	.20	SET UP SMALL MEDIUM LATHE	PRO RATE		.49962		.114	
0020	E		RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.011	
0030	E		RLA-BO-DG	2.00	BORE HOLE 1 1/2 - 2 DIA 1 DP2 LUGS			.21069		.484	
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0070	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0360		JA 01	15	.75		INST BRAKE EQUAL BUSH		.350	.039	.302	4
0040	E		RBW-BU-S1	.20	SET UP TO REBUSH BOSSES	PRO RATE		.18669		.042	
0050	E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES			.23835		.274	
0060	E		KTL-RM-B2	1.00	REAM BUSHING W ADJUST LEMPCO			.06442		.074	
0070	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0370		JA 01	15	.75		INST SNUBBER ATT BUSH		.431	.048	.372	5
0010	E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES			.18669		.214	
0020	E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES			.23835		.274	
0030	E		RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC			.00601		.006	
0990		JA 01	15	.01		LABOR STANDARD HISTORY		.000	.000	.000	0
0010					INITIAL INPUT MARCH 1983						
0020					20APR85 DOWNGRADE TO N STD TIME WAS 4.36 HRS						
0990					MANEL CLINTON BENTLEY MRP II 7-3255						

TO INTERROGATE LABOR STANDARDS, INPUT

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 RCC PRD NROP NR
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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 07/20/88 A-E046B-MM1-DY-M45 PAGE 0001

69657A STRUT KC135 MLG L/H RCC MNPRA 4S1-56-3 038-9102 83083

JOB STEP	TECH	S	S	W	F	PF	A/R	REV	SUPPORT ELEMENT	OCC FACT	DESCRIPTION		BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
	T	K		R	A	FA	C	DC			STORED	SUPPLEMENTAL				
RA015	E	N	JA	EA	1		J	83083		.20	PERCENT ENGR 12.6	MACHINE LOWER BEARING 303N	2.63		.52	
0001			JA	01		00				.00		PART NUMBER/NSN	.000	.000	.000	0
0010											7653528-01	31200104039 38				
0028			JA	01		15				1.00		MODIFY BEARING	2.000	.300	2.300	87
0010	N									1.00		MODIFY	2.00000		2.300	
0030			JA	01		15				1.00		REIDENTIFY	.288	.043	.332	13
0010	E								RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316	
0020	E								KID-MS-01	1.00	METAL STAMP 1ST DIGIT		.00326		.003	
0030	E								RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0990			JA	01		15				.01		LABOR STANDARD HISTORY	.000	.000	.000	0
0010											INITIAL INPUT MARCH 83					
0990											K W SHIPLEY MANEAA 63357					
0999											MANEL CLINTON BENTLEY MRP II 7-3255					

TO INTERROGATE LABOR STANDARDS, INPUT

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 RCC PRD NROP NR
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69657A STRUT KC135 MLG L/H RCC MMPRA 4S1-56-3 038-9102 83083

SUB STEP	TECH D	S T L	S K	W R K	F A C	PF FA DC	A/R REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT
RA017	S	E	JA	EA	1	J	83083	1.00	PERCENT ENGR 99.9	KC 135 MLG PISTON ROD	.21		.21	
0001			JA	01		00		.00		PART NUMBER/NSN	.000	.000	.000	0
0010									7531269-30	1620010273442				
0025			JA	01		15		1.00		CHECK STRAIGHTNESS	.188	.028	.217	100
0010	E					RBW-SU-G1		.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27525		.079	
0020	E					GIG-GM-C6		1.00	CHECK CONCENTRICITY		.10960		.126	
0030	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0990			JA	01		15		.01		LABOR STANDARD HISTORY	.000	.000	.000	0
0010									INITIAL INPUT MRP II FEBRUARY 88					
0999									MANEL CLINTON BENTLEY MRP II 7-3255					

TO INTERROGATE LABOR STANDARDS, INPUT

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 RCC PRD MROP NR
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0010                    INITIAL INPUT MAR 1983
0020                    20APR85 DOWNGRADE TO N STD - WAS 7.23 HRS
0990                    MANEL CLINTON BENTLEY MRP II  7-3255


 TO INTERROGATE LABOR STANDARDS, INPUT

  RCC PRD NROP NR
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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 08/17/88 A-E046B-MM1-DY-M45 PAGE 0001

69657A STRUT KC135 MLG L/H RCC MNPRB 4S1-56-3 038-9102 83083

TECH STEP	S T D	S K L	W #R K	F A C	PF FA DC	A/R SUPPORT ELEMENT	REV OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
RB013	S	N	JA EA	3	J	83083	.75	PERCENT ENGR 79.1	GRIND CYLINDER ASSY 30°E	13.87		10.40		
0001			JA 01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010								65-5763-17	1620009274739					
0020								65-5763-18	1620009592070					
0030								50-9712-32	1620007871750					
0040								50-9712-31	1620007871749					
0040			JA 01	15			.10		GND NCKL.OR CORRO.FR.TRUN.FA	3.711	.056	.427		3
0010	E			RGR-SU-J3			.25	S-U JIG GRINDER LRG FXT HST PRO RATE		1.03687		.298		
0020	E			RML-HP-CC			1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181		
0030	E			RML-AL-AA			2.00	ALIGN HORIZ AXIS ROD	2 LUGS	.06265		.144		
0040	E			KMG-DW-OD			2.00	DRESS EXTERNAL WHEEL	2 TIMES	.02308		.053		
0050	N						4.00		GRIND 4 LUG FACES	.75000		3.450		
0060	E			RGR-HM-C5			1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134		
0070	E			RJP-PW-F1			1.00	SIGN OFF WORK CONTROL DOC		.00601		.006		
0050			JA 01	15			.10		GND.NCKL.OR CORRO.FRM DRG S.	4.611	.069	.530		4
0010	E			RGR-SU-J3			.25	S-U JIG GRINDER LRG FXT HST PRO RATE		1.03687		.298		
0020	E			RML-HP-CC			1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181		
0030	E			RML-AL-AA			2.00	ALIGN HORIZ AXIS ROD	2 TIMES	.06265		.144		
0040	E			KMG-DW-OD			2.00	DRESS EXTERNAL WHEEL	2 TIMES	.02308		.053		
0050	N						6.00		GRIND 6 LUG FACES	.65000		4.485		
0060	E			RGR-HM-C5			1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134		
0070	E			RJP-PW-F1			1.00	SIGN OFF WORK CONTROL DOC		.00601		.006		
0			JA 01	15			.10		GND NCKL OR CORR.FRM.S.B.FAC	2.161	.032	.249		2
0010	E			RGR-SU-J3			.25	S-U JIG GRINDER LRG FXT HST PRO RATE		1.03687		.298		
0020	E			RML-HP-CC			1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181		
0030	E			RML-AL-AA			2.00	ALIGN HORIZ AXIS ROD	2 TIMES	.06265		.144		
0040	E			KMG-DW-OD			2.00	DRESS EXTERNAL WHEEL	2 TIMES	.02308		.053		
0050	N						2.00		GRIND 2 FACES	.72500		1.667		
0060	E			RGR-HM-C5			1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134		
0070	E			RJP-PW-F1			1.00	SIGN OFF WORK CONTROL DOC		.00601		.006		
0070			JA 01	15			.10		GND NKL.OR CORRO.FRM.TOR.L.F	3.757	.056	.432		3
0010	E			RGR-SU-J3			.25	S-U JIG GRINDER LRG FXT HST PRO RATE		1.03687		.298		
0020	E			RML-HP-CC			1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181		
0030	E			RML-AL-AA			2.00	ALIGN HORIZ AXIS ROD	2 TIMES	.06265		.144		
0040	E			KMG-DW-OD			4.00	DRESS EXTERNAL WHEEL	4 TIMES	.02308		.106		
0050	N						4.00		GRIND 4 FACES	.75000		3.450		
0060	E			RGR-HM-C5			1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134		
0070	E			RJP-PW-F1			1.00	SIGN OFF WORK CONTROL DOC		.00601		.006		
0260			JA 01	15			.38		GRD UPBORE FR CHROME PLATE	6.111	.348	2.671		19
0010	E			RGR-SU-I2			.50	SET UP LRG INTERNAL GRINDER		1.53372		.881		
0020	E			RML-SU-F3			.50	LRG FIXTUR TO/FRM MACH HOIST		.45621		.262		
0030	E			RGR-HP-L1			1.00	LOAD LARGE PART GAP GRINDER		.13653		.157		
0050	E			KMG-GW-LK			1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E			KMG-ID-SE			4.00	GRIND OUT .010 10 ID X 3	4 X LENGTH	1.19745		5.508		
0070	E			RGR-HM-C5			1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134		
0080	E			RJP-PW-F1			1.00	SIGN OFF WORK CONTROL DOC		.00601		.006		
0270			JA 01	15			.28		GRD LWBORE FR CHROME PLATE	3.717	.156	1.197		9
0010	E			RGR-SU-I2			.50	SET UP LRG INTERNAL GRINDER	PRO RATE	1.53372		.881		
0020	E			RML-SU-F3			.50	LRG FIXTUR TO/FRM MACH HOIST		.45621		.262		
0030	E			RGR-HP-L1			1.00	LOAD LARGE PART GAP GRINDER		.13653		.157		
0050	E			KMG-GW-LK			1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E			KMG-ID-SE			2.00	GRIND OUT .010 10 ID X 3	2 TIMES LENGTH	1.19745		2.754		
0070	E			RGR-HM-C5			1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134		

0080 E		RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC			.00601		.006	
0440	JA 01	15	.10		FIN GND TRUN LUG FACE		4.534	.068	.521	4
0010 E		RGR-SU-J3	.25	S-U JIG GRINDER LRG FXT HST PRO RATE			1.03687		.298	
0020 E		RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP			.15776		.181	
0030 E		RML-AL-AA	2.00	ALIGN HORIZ AXIS ROD	2 LUGS		.06265		.144	
0040 E		KMG-DW-OD	3.00	DRESS EXTERNAL WHEEL	3 TIMES		.02308		.079	
0050 N			4.00		GRIND 4 LUG FACES		.95000		4.370	
0060 E		RGR-HM-C5	1.00	HANDLE & MEAS LENGTH 24 - 36			.11700		.134	
0070 E		RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC			.00601		.006	
0450	JA 01	15	.10		FIN GRD DRAG STRUT LUG FACES		5.211	.078	.599	4
0010 E		RGR-SU-J3	.25	S-U JIG GRINDER LRG FXT HST PRO RATE			1.03687		.298	
0020 E		RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP			.15776		.181	
0030 E		RML-AL-AA	2.00	ALIGN HORIZ AXIS ROD	2 TIMES		.06265		.144	
0040 E		KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL	2 TIMES		.02308		.053	
0050 N			6.00		GRIND 6 LUG FACES		.75000		5.175	
0060 E		RGR-HM-C5	1.00	HANDLE & MEAS LENGTH 24 - 36			.11700		.134	
0070 E		RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC			.00601		.006	
0460	JA 01	15	.10		FIN GRD SIDE BRACE LUG FACE		2.561	.038	.295	2
0010 E		RGR-SU-J3	.25	S-U JIG GRINDER LRG FXT HST PRO RATE			1.03687		.298	
0020 E		RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP			.15776		.181	
0030 E		RML-AL-AA	2.00	ALIGN HORIZ AXIS ROD	2 TIMES		.06265		.144	
0040 E		KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL	2 TIMES		.02308		.053	
0050 N			2.00		GRIND 2 LUG FACES		.92500		2.127	
0060 E		RGR-HM-C5	1.00	HANDLE & MEAS LENGTH 24 - 36			.11700		.134	
0070 E		RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC			.00601		.006	
0470	JA 01	15	.10		FIN GND TOR LUG FACE		4.457	.067	.513	4
0010 E		RGR-SU-J3	.25	S-U JIG GRINDER LRG FXT HST PRO RATE			1.03687		.298	
0020 E		RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP			.15776		.181	
0030 E		RML-AL-AA	2.00	ALIGN HORIZ AXIS ROD	2 TIMES		.06265		.144	
0040 E		KMG-DW-OD	4.00	DRESS EXTERNAL WHEEL	4 TIMES		.02308		.106	
0050 N			4.00		GRIND 4 LUG FACES		.92500		4.255	
0060 E		RGR-HM-C5	1.00	HANDLE & MEAS LENGTH 24 - 36			.11700		.134	
0070 E		RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC			.00601		.006	
0480	JA 01	15	.38		FIN GRIND UPPER BORE		10.408	.593	4.548	33
0010 E		RGR-SU-I2	.50	SET UP LRG INTERNAL GRINDER PRO RATE			1.53372		.881	
0020 E		RML-SU-F3	.50	LRG FIXTUR TO/FRM MACH HOIST			.45621		.262	
0030 E		RGR-HP-L1	1.00	LOAD LARGE PART GAP GRINDER			.13653		.157	
0050 E		KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION			.06761		.077	
0060 E		KMG-ID-SK	4.00	GRIND OUT .040 10 ID X3	4 TIMES LENGTH		2.27158		10.449	
0070 E		RGR-HM-C5	1.00	HANDLE & MEAS LENGTH 24 - 36			.11700		.134	
0080 E		RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC			.00601		.006	
0490	JA 01	15	.28		FIN GRIND LOWER BORE		5.865	.246	1.889	14
0010 E		RGR-SU-I2	.50	SET UP LRG INTERNAL GRINDER PRO RATE			1.53372		.881	
0020 E		RML-SU-F3	.50	LRG FIXTUR TO/FRM MACH HOIST			.45621		.262	
0030 E		RGR-HP-L1	1.00	LOAD LARGE PART GAP GRINDER			.13653		.157	
0050 E		KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION			.06761		.077	
0060 E		KMG-ID-SK	2.00	GRIND OUT .040 10 ID X3	2 X LENGTH		2.27158		5.224	
0070 E		RGR-HM-C5	1.00	HANDLE & MEAS LENGTH 24 - 36			.11700		.134	
0080 E		RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC			.00601		.006	
0990	JA 01	15	.01		LABOR STANDARD HISTORY		.000	.000	.000	0
0010				INITIAL INPUT MAR83						
0990				MANEL CLINTON BENTLEY MRP II 7-3255						

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RCC PRD NROP NR
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1234567890123456 ELSE PUT IN END

69657A STRUT KC135 MLG L/H RCC MNPRB 4S1-56-3 038-9102 83083

JOB STEP	TECH D	S L	S K	W #R	F A C	PF FA DC	A/R REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
RB014	S	E	JA	EA	3	J	83083	.75	PERCENT ENGR 80.5	GRIND PISTON KC135 MLG 303E	9.98		7.48		
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010									65-1265-7	1620009816337					
0020									65-1265-8	1620000842104					
0140			JA	01	15			.10		1ST GND TORQUE LUG FACE	3.757	.056	.432		4
0010	E				RGR	SU	J3	.25	S-U JIG GRINDER LRG FXT HST	PRO RATE	1.03687		.298		
0020	E				RML	HP	CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181		
0030	E				RML	AL	AA	2.00	ALIGN HORIZ AXIS ROD	2 TIMES	.06265		.144		
0040	E				KMG	DW	OD	4.00	DRESS EXTERNAL WHEEL	4 TIMES	.02308		.106		
0050	N							4.00		GRIND 4 FACES	.75000		3.450		
0060	E				RGR	HM	C5	1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134		
0070	E				RJP	PW	F1	1.00	SIGN OFF WORK CONTROL DOC		.00601		.006		
0150			JA	01	15			.50		1ST GRIND PISTON O D	4.463	.335	2.566		26
0010	E				RGR	SU	G1	.50	SET UP A GAP GRINDER	PRO RATE	1.05938		.609		
0020	E				RGR	HP	L3	1.00	LOAD EX LRG PRT GAP GR FIXT		.36081		.414		
0030	E				RGR	HM	T2	.50	ADJUST TAPER - GAP GRINDER	PRO RATE	.02632		.015		
0040	E				KMG	DW	OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E				KMG	OD	SE	4.00	GRIND .010 10DIA X 3 LONG		.85335		3.925		
0060	E				RGR	HM	C5	1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134		
0070	E				RJP	PW	F1	1.00	SIGN OFF WORK CONTROL DOC		.00601		.006		
0160			JA	01	15			.50		1ST GRIND SEAL AREA	1.840	.138	1.058		11
0010	E				RGR	SU	P1	.50	SET UP PLANETARY GRINDER	PRO RATE	.82175		.472		
0020	E				RGR	HP	L1	1.00	LOAD LARGE PART GAP GRINDER		.13653		.157		
0030	E				KMG	DW	ID	1.00	DRESS INTERNAL WHEEL		.02458		.028		
0040	E				KMG	GW	LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0050	E				KMG	ID	RE	1.00	GRIND OUT .010 9 ID X 3		1.07779		1.239		
0060	E				RGR	HM	C5	1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134		
0070	E				RJP	PW	F1	1.00	SIGN OFF WORK CONTROL DOC		.00601		.006		
0250			JA	01	15			.10		FIN GRING TORQUE LUG FACES	4.457	.067	.513		5
0010	E				RGR	SU	J3	.25	S-U JIG GRINDER LRG FXT HST	PRO RATE	1.03687		.298		
0020	E				RML	HP	CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181		
0030	E				RML	AL	AA	2.00	ALIGN HORIZ AXIS ROD	2 TIMES	.06265		.144		
0040	E				KMG	DW	OD	4.00	DRESS EXTERNAL WHEEL	4 TIMES	.02308		.106		
0050	N							4.00		GRIND 4 FACES	.92500		4.255		
0060	E				RGR	HM	C5	1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134		
0070	E				RJP	PW	F1	1.00	SIGN OFF WORK CONTROL DOC		.00601		.006		
0260			JA	01	15			.50		FIN GRIND CYL OD	6.589	.494	3.789		38
0010	E				RGR	SU	G1	.50	SET UP A GAP GRINDER	PRO RATE	1.05938		.609		
0020	E				RGR	HP	L3	1.00	LOAD EX LRG PRT GAP GR FIXT		.36081		.414		
0030	E				RGR	HM	T2	.50	ADJUST TAPER - GAP GRINDER	PRO RATE	.02632		.015		
0040	E				KMG	DW	OD	3.00	DRESS EXTERNAL WHEEL	3 TIMES	.02308		.079		
0050	E				KMG	OD	SK	4.00	GRIND .040 FROM 10 IN D X 3		1.37336		6.317		
0060	E				RGR	HM	C5	1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134		
0070	E				RJP	PW	F1	1.00	SIGN OFF WORK CONTROL DOC		.00601		.006		
0270			JA	01	15			.50		FIN GRIND SEAL AREA	2.831	.212	1.628		16
0010	E				RGR	SU	P1	.50	SET UP PLANETARY GRINDER	PRO RATE	.82175		.472		
0020	E				RGR	HP	L1	1.00	LOAD LARGE PART GAP GRINDER		.13653		.157		
0030	E				KMG	DW	ID	2.00	DRESS INTERNAL WHEEL	2 TIMES	.02458		.056		
0040	E				KMG	GW	LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0050	N							1.00		GRIND SEAL KMGIDRK	2.04400		2.350		
0060	E				RGR	HM	C5	1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134		
0070	E				RJP	PW	F1	1.00	SIGN OFF WORK CONTROL DOC		.00601		.006		
0990			JA	01	15			.01		LABOR STANDARD HISTORY	.000	.000	.000		0

69657A STRUT KC135 MLG L/H RCC MNPGP 4S1-56-3 038-9102 83086

PER STEP	TECH D	S T L	S K	W R	F A	PF FA DC	A/R REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY	A PCT	C
0010	E	N	HB	EA	5	J	88174	1.00	PERCENT ENGR .0	ASSY STRUT KC-135	6.09		6.09			
0001			HB	00	00			.00		PART NO/NSN	.000	.000	.000			0
0010									7531273-80	1620010389103						
0020									7531273-70	1620010389100						
0030									7531273-90	1620010389102						
0040									7531273-100	1620010389101						
0501			HB	01	00			1.00		PRE-ASSY CLEAN	.235	.000	.235			4
0010		N						1.00		CLEAN	.23500		.235			
0502			HB	01	00			1.00		OK TO CLOSE/ASSEMBLE	3.400	.000	3.400			56
0010		N						1.00		ASSEMBLE	3.40000		3.400			
0504			HB	01	00			1.00		TORQUE ALL	.500	.000	.500			8
0010		N						1.00		TORQUE PARTS A/R	.50000		.500			
0505			HB	01	00			1.00		CHECK STROKE	1.500	.000	1.500			25
0010		N						1.00		STROKE	1.50000		1.500			
0506			HB	01	00			1.00		PRESSURE TEST	.460	.000	.460	2.4		8
0010		N						1.00		TEST	.46000		.460			
9000			HB	01	21			.01		LABOR STANDARD HISTORY	.000	.000	.000			0
0010									INITIAL INPUT MARCH 1983							
0020									20APR85-DOWNGRADE TO N STD-TIME WAS 3.24 HRS							
0025									24 MAY 85 - MOVED TEST FROM SKILL CODE TO							
0026									TO SKILL CODE HB - TIME WAS 3.24 HRS							
0990									K W SHIPLEY MANEAA 63357							

TO INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 07/20/88 A-E046B-MM1-DY-M45 PAGE 0001

69657A STRUT KC135 MLG L/H RCC MMPGP 4S1-56-3 038-9102 83086

SUB STEP	TECH D	S S T K L	W #R K	F A C	PF FA DC	A/R REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
PM043	S	N	DI	EA	5	J 88173	1.00	PERCENT ENGR 64.7	MATCH UP STRUT KC 135	.98		.98	
0001			DI	00	00		.00		PART NO/NSN	.000	.000	.000	0
0010								7531273-80	1620010389103				
0010			DI	01	21		1.00		MATCH UP STRUT	.813	.171	.985	100
0010	N						1.00		SORT/STORE NON RTD PART	.20700		.347	
0020	E					RLG-MU-01	1.00	MATCH UP PARTS FOR ASSEMBLY		.52681		.637	
9000			DI	01	21		.01		LABOR STD HISTORY	.000	.000	.000	0
0010								INITIAL INPUT MARCH 83					
0020								20APR85-DOWNGRADE TO N STD- TIME WAS 0.81 HRS					
0990								K W SHIPLEY MANEAA 63357					

TO INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 07/20/88 A-E046B-MM1-DY-MA5 PAGE 0001

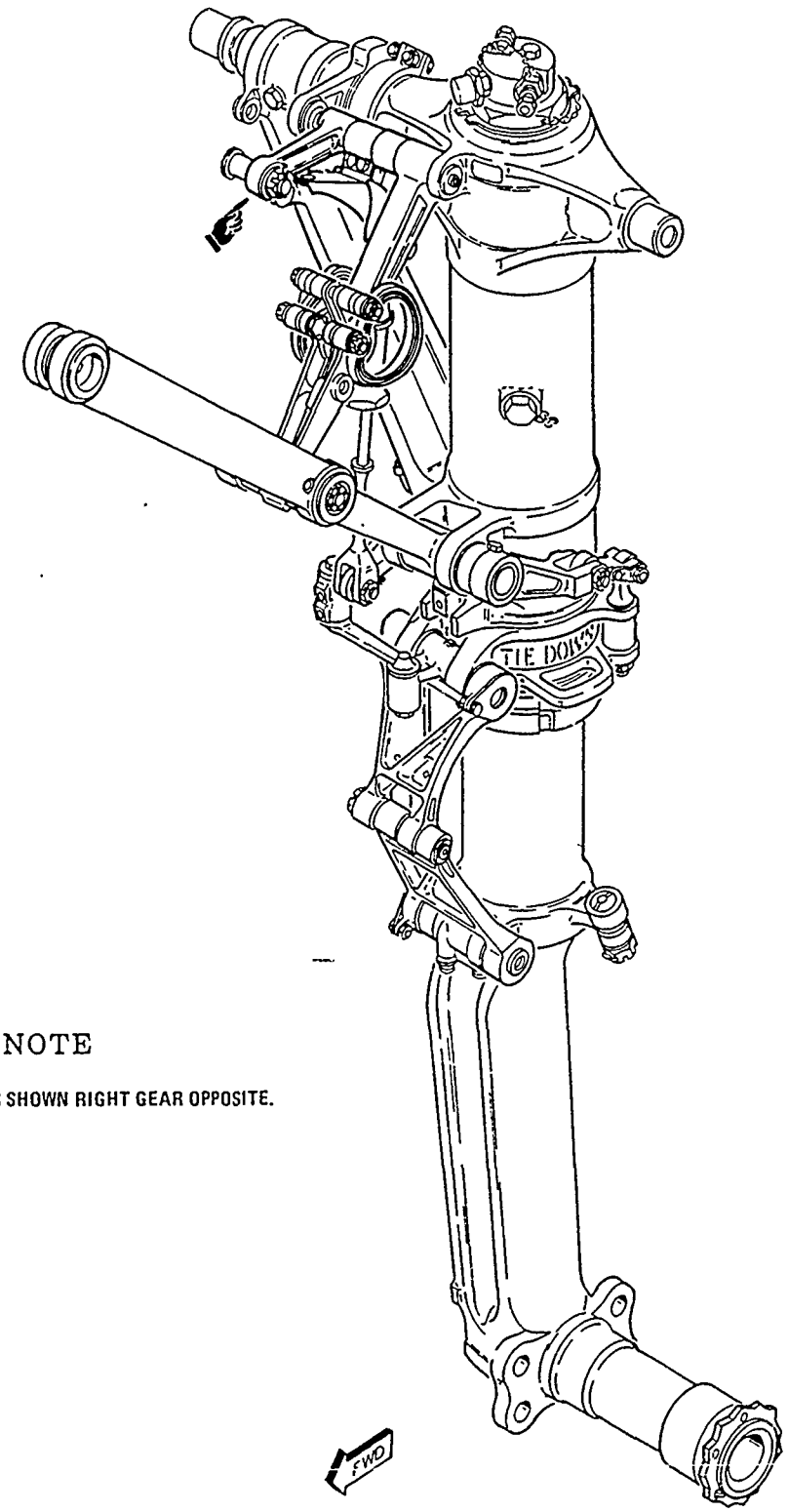
69657A STRUT KC135 MLG L/H RCC MNPGP 4S1-56-3 038-9102 83086

SUB STEP	TECH D	S T L	S K R	W F A C	PF FA DC	A/R REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY	PCT	A C
PP043	S	E 3S	EA 5		J	88173	1.00	PERCENT ENGR 80.4	PAINT STRUT ASSY KC 135	1.62		1.62			
0001		3S	00	00			.00		PART NO/NSN	.000	.000	.000			0
0010								7531273-80	1620010389103						
0510		3S	01	25			1.00		PAINT LARGE STRUT ASSY	.956	.239	1.196	4.0	73	
0010	E			ZLG	HH	03	1.00	LOAD LRG STRUT ON O/H CONV	LOAD OVERHEAD CRANE	.03515		.043			
0020	E			ZMA	MN	L1	1.00	MASK LRG MLG STRUT FNL PAINT		.30702		.383			
0030	E			ZMP	SP	F3	1.00	FINAL PAINT LRG STRUT/PART		.40789		.509			
0040	E			RLG	JP	DS	1.00	GET STRUT DECALS F/STO CAB		.00693		.008			
0050	E			ZMP	UM	03	1.00	UNMASK LRG STRUT AFTER PAINT		.14110		.176			
0060	E			ZLG	HH	U1	1.00	UNLOAD OVERHEAD CONVEYOR		.03462		.043			
0070	E			KID	DL	AA	1.00	INSTALL DECAL PR SENSITIVE		.01378		.017			
0080	E			RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012			
0512		3S	01	25			1.00		DECALS	.030	.008	.038			2
0010	E			RLG	JP	DS	1.00	GET STRUT DECALS F/STO CAB		.00693		.008			
0020	E			KID	DL	AA	1.00	INSTALL DECAL PR SENSITIVE		.01378		.017			
0030	E			RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012			
0515		3S	01	24			1.00		FINAL ACCEPTANCE OF W.C.D.	.180	.043	.224			14
0010	N						1.00		FINAL	.12800		.158			
0020	E			GJP	FP	B5	1.00		FILL OUT FORM 424 & ATTACH	.05255		.065			
0516		3S	01	24			1.00		FINAL VISUAL INSPECTION	.137	.033	.170			10
0010	N						1.00		FINAL VISUAL INSPECTION	.12700		.157			
0020	E			RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012			

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F-15 MLG



NOTE

1. LEFT GEAR SHOWN RIGHT GEAR OPPOSITE.

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Main Landing Gear Assembly

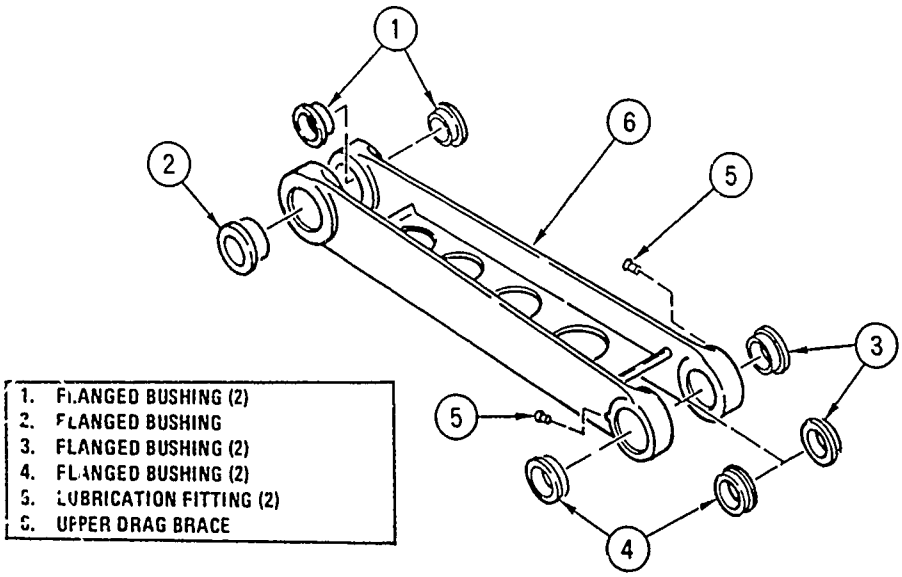


Figure 3-1. Upper Drag Brace Assembly

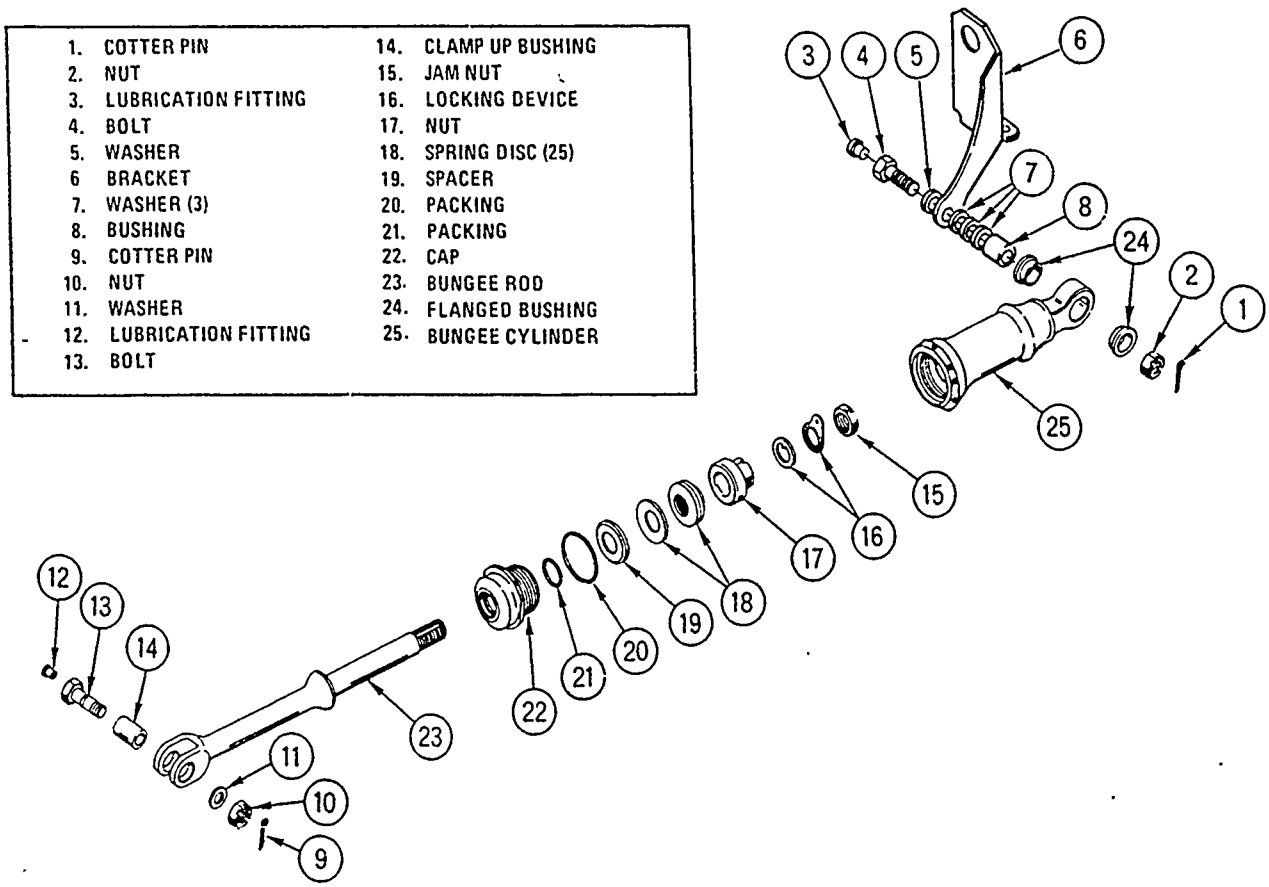


Figure 3-2. Bungee Assembly

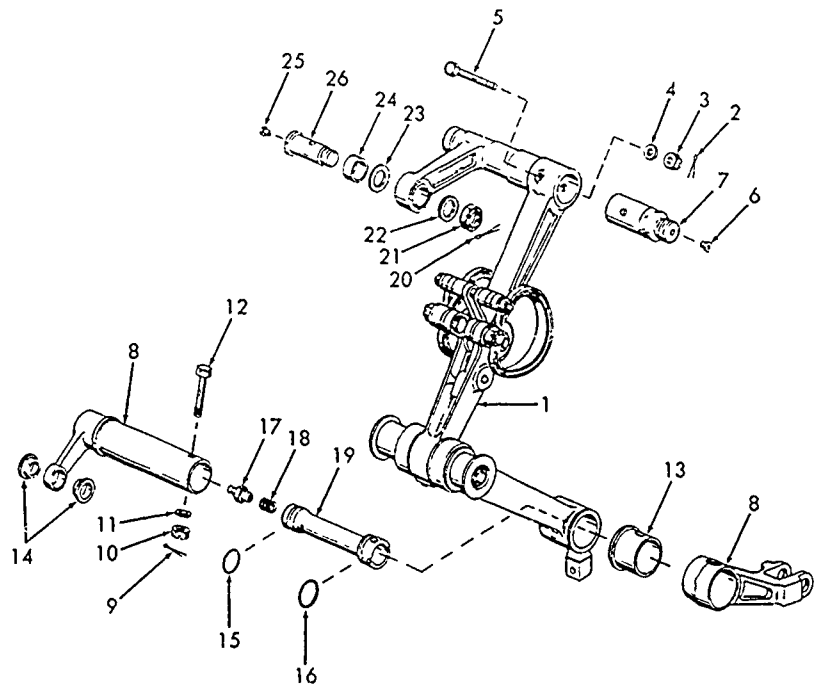


Figure 3-3. Lower Drag Brace and Jury Link

CAUTION

To prevent damage to parts, lugs must be supported when removing bushings.

g. Do not remove flanged bushings (33), sleeve bushing (34), or lubrication fitting (35) from lower jury link (32). If replacement of bushings is necessary, drive out bushings.

h and i. Deleted

CAUTION

To prevent damage to parts, lugs must be supported when removing bushings.

j. Do not remove flanged bushings (43), spherical bearing (42), or lubrication fitting (44) from upper jury link (41). If replacement of bushings is necessary, drive out bushings. If replacement of spherical bearing is necessary, refer to section V for replacement procedures.

3-8. DISASSEMBLING SWIVEL CONNECTING LINK. See figure 3-5.

CAUTION

To prevent damage to unpainted or bare metal parts, handle with extreme care as they may be easily damaged.

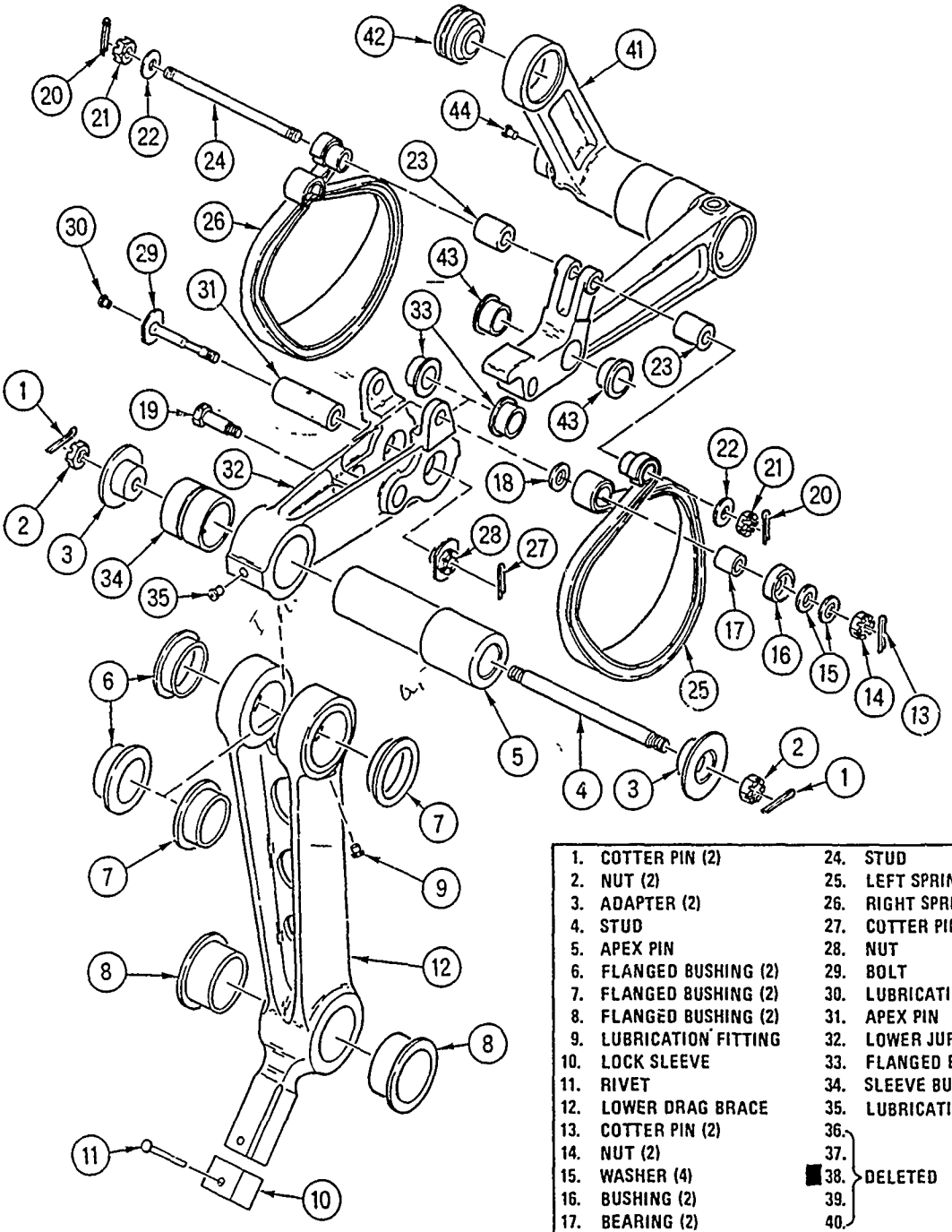
a. Remove cotter pin (1), nut (2), tang washer (3), and shim washer (4) securing collar spindle (15) to collar on strut cylinder. Remove collar spindle with swivel link (26) assembled.

b. Remove lockwire from nut (6) if installed, and remove nut (6), washer (7) and bolt (8); remove locking plate (5) from swivel link (26).

CAUTION

To prevent damage to parts, lugs must be supported when removing bushings.

c. Remove cotter pin (9), nut (10), washer (11), and eccentric bolt (12); separate collar spindle (15) from swivel link (26). Do not remove lubrication fitting (13) or flanged bushings (14) from collar spindle. If necessary to replace bushings, drive out bushings.

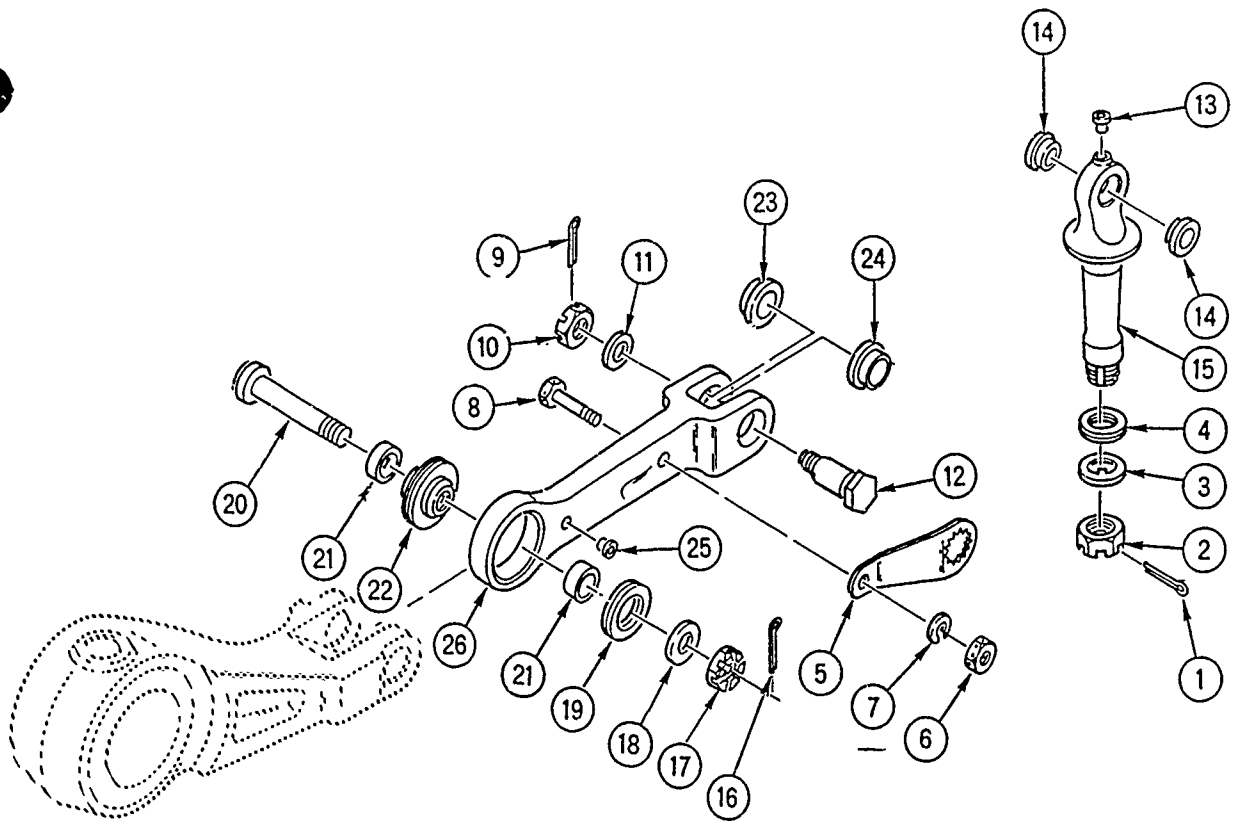


1.	COTTER PIN (2)	24.	STUD
2.	NUT (2)	25.	LEFT SPRING
3.	ADAPTER (2)	26.	RIGHT SPRING
4.	STUD	27.	COTTER PIN
5.	APEX PIN	28.	NUT
6.	FLANGED BUSHING (2)	29.	BOLT
7.	FLANGED BUSHING (2)	30.	LUBRICATION FITTING
8.	FLANGED BUSHING (2)	31.	APEX PIN
9.	LUBRICATION FITTING	32.	LOWER JURY LINK
10.	LOCK SLEEVE	33.	FLANGED BUSHING (2)
11.	RIVET	34.	SLEEVE BUSHING
12.	LOWER DRAG BRACE	35.	LUBRICATION FITTING
13.	COTTER PIN (2)	36.	
14.	NUT (2)	37.	
15.	WASHER (4)	■38.	DELETED
16.	BUSHING (2)	39.	
17.	BEARING (2)	40.	
18.	WASHER (2)	41.	UPPER JURY LINK
19.	BOLT (2)	42.	SPHERICAL BEARING
20.	COTTER PIN (2)	43.	FLANGED BUSHING (2)
21.	NUT (2)	44.	LUBRICATION FITTING
22.	WASHER (2)	45.	
23.	SPACER (2)	■46.	DELETED
		47.	

4A4-22-3-(41D

Figure 3-4. Lower Drag Brace and Jury Links

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1. COTTER PIN	14. FLANGED BUSHING (2)
2. NUT	15. COLLAR SPINDLE
3. TANG WASHER	16. COTTER PIN
4. SHIM WASHER	17. NUT
5. LOCKING PLATE	18. WASHER
6. NUT	19. SHIM WASHER
7. WASHER	20. SWIVEL APEX BOLT
8. BOLT	21. SLEEVE BUSHING (2)
9. COTTER PIN	22. SPHERICAL BEARING
10. NUT	23. FLANGED BUSHING
11. WASHER	24. FLANGED BUSHING
12. ECCENTRIC BOLT	25. LUBRICATION FITTING
13. LUBRICATION FITTING	26. SWIVEL LINK

4A4-22-3-(5)A

Figure 3-5. Swivel Connecting Link

1. COTTER PIN (2)
2. NUT (2)
3. FLAT WASHER (LAMINATED SHIM) (2)
4. BOLT (2)
5. COTTER PIN
6. NUT
7. WASHER
8. T-SEAL (4)
9. COTTER PIN
10. NUT
11. WASHER
12. PACKING
13. HYDRAULIC FITTING
14. PACKING
15. HYDRAULIC FITTING
16. DOWEL PIN
17. SWIVEL SHAFT
18. T-SEAL
19. BOLT
20. WASHER
21. PIN
22. HYDRAULIC TRANSFER CRANK
23. HYDRAULIC TRANSFER LINK
24. T-SEAL (4)
25. UPPER MANIFOLD
26. T-SEAL (8)
27. TORQUE ARM PIN
28. NUT
29. WASHER
30. BOLT
31. T-SEAL (4)
32. PACKING
33. HYDRAULIC FITTING
34. PACKING
35. HYDRAULIC FITTING
36. LOWER MANIFOLD
37. T-SEAL (8)
38. TORQUE ARM PIN
39. NUT
40. WASHER
41. BOLT
42. T-SEAL (8)
43. TORQUE ARM (2)
44. COTTER PIN
45. NUT
46. TANG WASHER
47. LUBE WASHER (4)
48. APEX BOLT

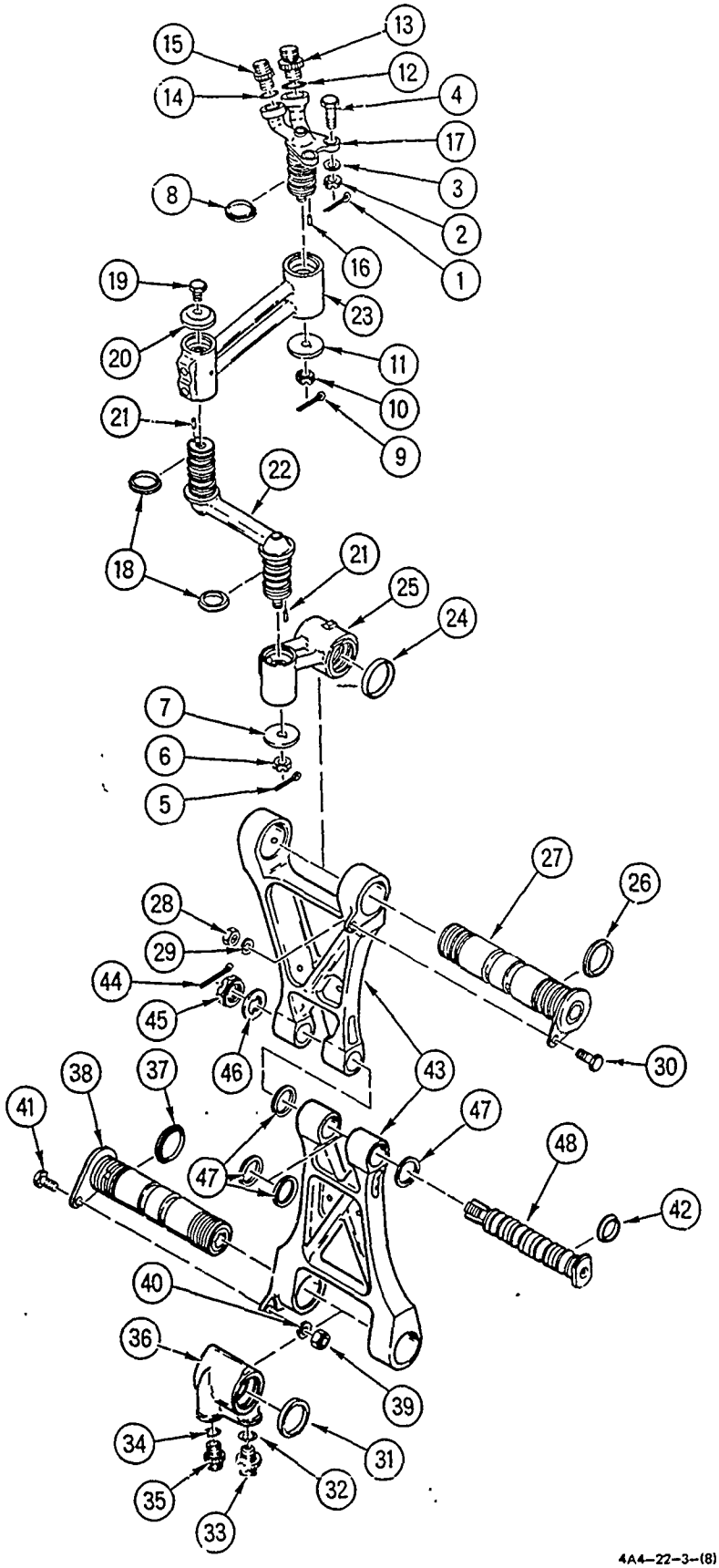
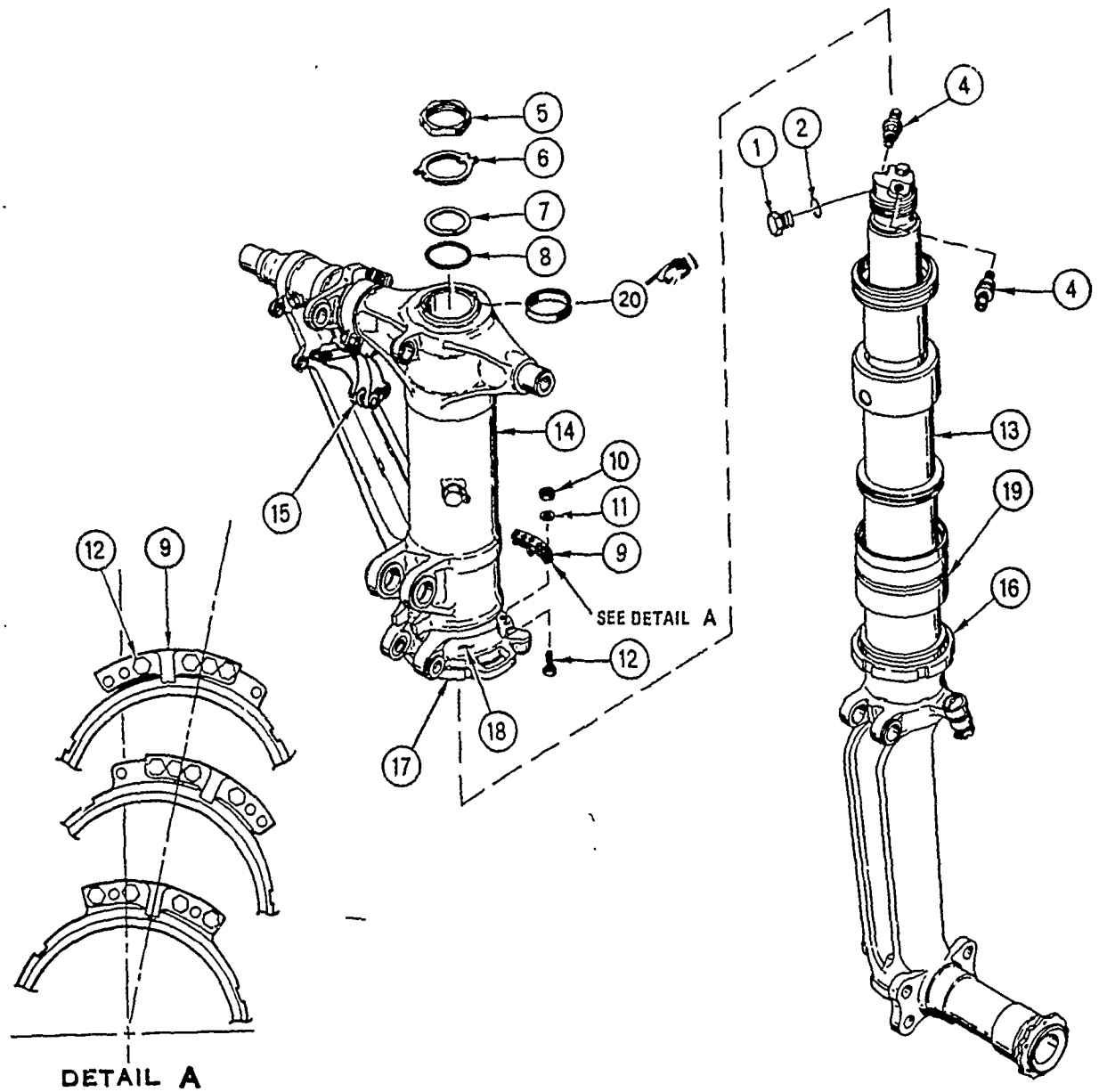


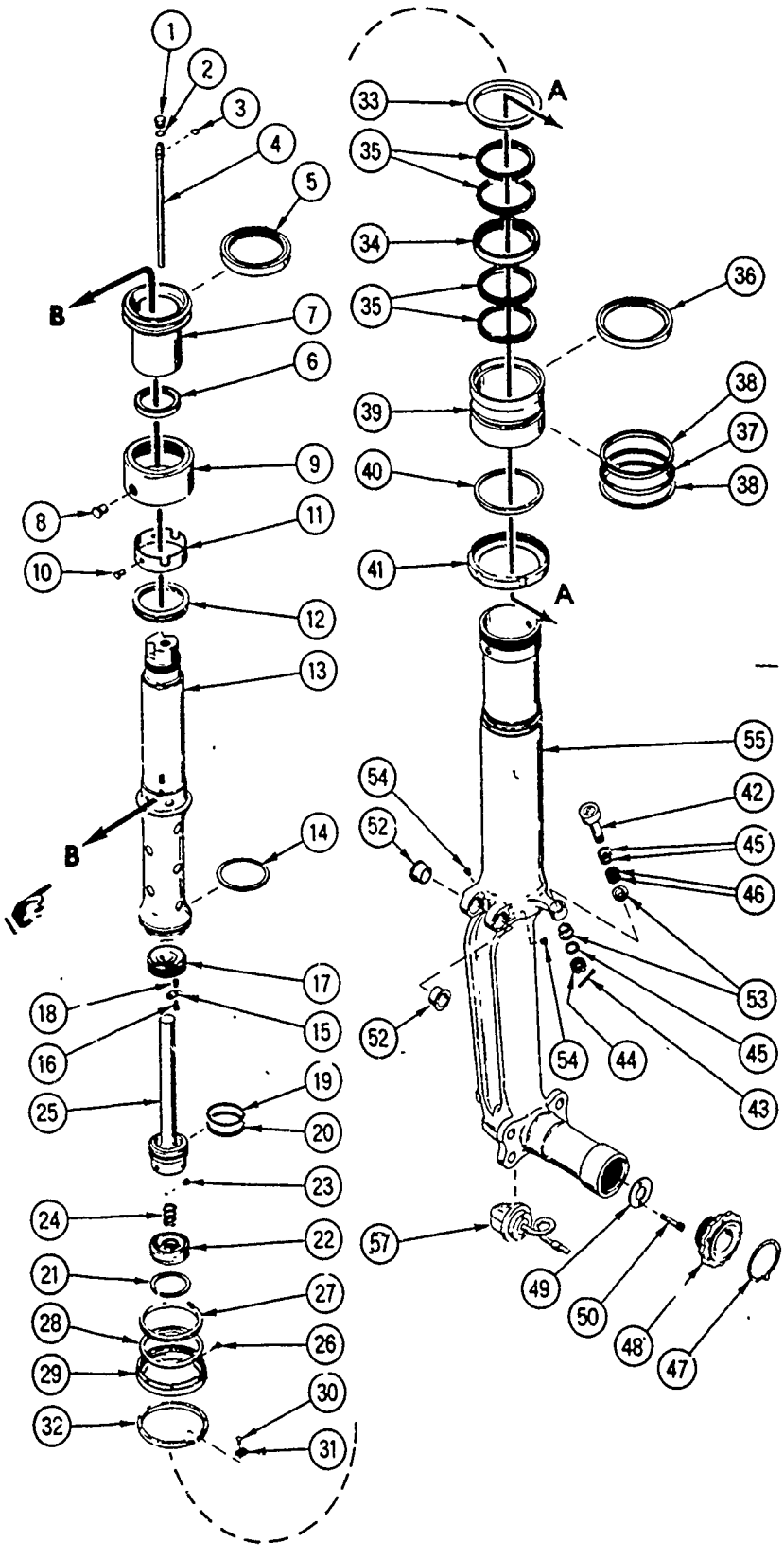
Figure 3-6. Torque Arms, Crank, and Link Assembly



1. PLUG
2. PACKING
3. DELETED
4. AIR VALVE (2)
5. NUT
6. RETAINER
7. RETAINER RING
8. PACKING
9. LOCK TAB
10. NUT (4)
11. WASHER (4)
12. BOLT (4)
13. PISTON AND ORIFICE SUPPORT TUBE ASSEMBLY
14. STRUT CYLINDER ASSEMBLY
15. BRACKET
16. GLAND NUT
17. COLLAR RETAINING NUT
18. COLLAR
19. LOWER BEARING
20. ORIFICE SUPPORT TUBE BUSHING

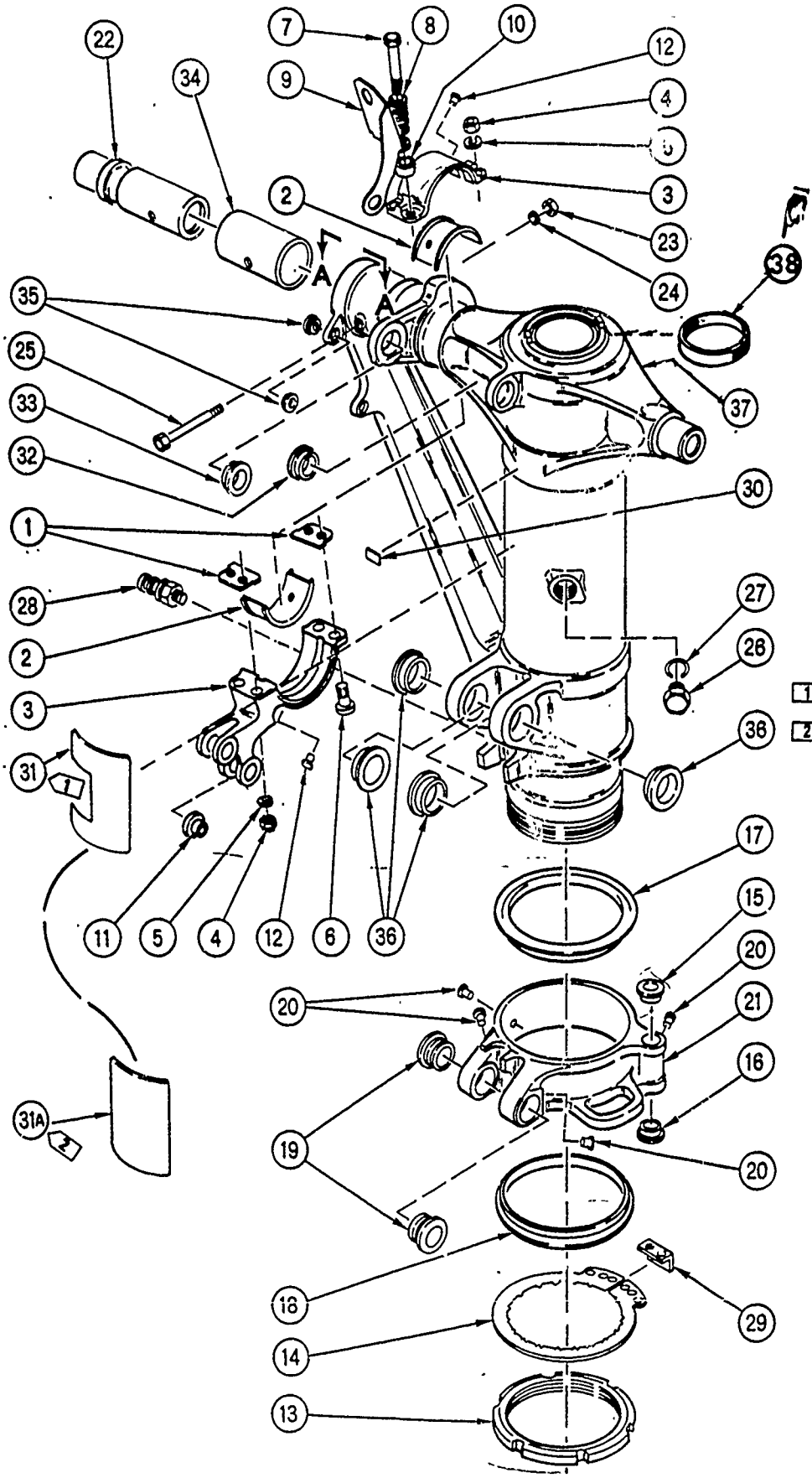
4A4-22-3-(910

Figure 3-7. Piston and Orifice Support Tube Assembly



1.	PLUG
2.	PACKING
3.	PACKING
4.	STAND PIPE
5.	T – RING SEAL
6.	T – RING SEAL
7.	HIGH PRESSURE PISTON
8.	PISTON HEAD PIN (2)
9.	PISTON HEAD
10.	RIVET
11.	RETAINING RING
12.	THRUST BEARING
13.	ORIFICE SUPPORT TUBE
14.	PISTON RING
15.	LOCK TAB
16.	SCREW (2)
17.	RESTRICTOR ASSEMBLY
18.	HELICOIL INSERT
19.	PACKING
20.	RETAINER RING
21.	RETAINING RING
22.	LOCK
23.	HEADED STRAIGHT PIN (3)
24.	SPRING
25.	METERING PIN
26.	LOCKING PIN
27.	POSITIONING RING
28.	SNUBBER STOP
29.	RETAINER
30.	RIVET
31.	INSERT
32.	REBOUND DAMPENER
33.	PACKING RETAINER
34.	SEAL
35.	RETAINER RING (4)
36.	SEAL (SPARE)
37.	SEAL
38.	RETAINER RING (2)
39.	LOWER BEARING
40.	SCRAPER
41.	GLAND NUT
42.	CAM FOLLOWER
43.	COTTER PIN
44.	NUT
45.	WASHER (3)
46.	SHIM (2)
47.	RING
48.	AXLE NUT
49.	RETAINER PLATE
50.	SCREW (2)
51.	CABLE ASSEMBLY
52.	FLANGED BUSHING (2)
53.	FLANGED BUSHING (2)
54.	LUBRICATION FITTING (2)
55.	PISTON

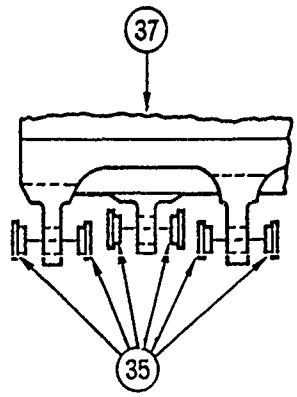
Figure 3-8. Piston and Orifice Support Tube Assembly and High Pressure Seal (Sheet 1 of 2)



1. BUSHING STOP PLATE (2)
2. BUSHING (2)
3. TRUNNION COLLAR
4. SELF-LOCKING NUT (2)
5. WASHER (2)
6. BOLT
7. BOLT
8. WASHER (5)
9. BRACKET
10. SPACER
11. FLANGED BUSHING
12. LUBRICATION FITTING (2)
13. COLLAR RETAINING NUT
14. KEYING WASHER
15. FLANGED BUSHING
16. FLANGED BUSHING
17. UPPER FLANGED BUSHING
18. LOWER FLANGED BUSHING
19. TORQUE ARM FLANGED BUSHING (2)
20. LUBRICATION FITTING (4)
21. COLLAR
22. TRUNNION PIN
23. NUT
24. WASHER
25. BOLT
26. PLUG
27. PACKING
28. AIR VALVE
29. INSTRUCTION PLATE
30. AGE CONTROL PLATE
31. NAME AND INSTRUCTION PLATE
31A. INSTRUCTION AND IDENTIFICATION PLATE
32. FLANGED BUSHING
33. FLANGED BUSHING
34. TRUNNION PIN BUSHING
35. FLANGED BUSHING (6)
36. FLANGED BUSHING (4)
37. STRUT CYLINDER
38. ORIFICE SUPPORT TUBE BUSHING

LEGEND

1 BEFORE TO 4A4-22-505
2 AFTER TO 4A4-22-505



VIEW A

4A4-22-3-(11)H

Figure 3-9. Strut Cylinder Assembly

SECTION I

GENERAL INFORMATION

1-1. PURPOSE.

1-2. The right and left main landing gears provide support for the aircraft during landing and ground operations. This is accomplished through three functional subassemblies: the shock strut, the drag brace, and the linear actuating cylinder assembly.

1-3. GENERAL INFORMATION.

1-4. This publication covers overhaul procedures for the left and right main retractable landing gears. Each landing gear consists principally of a shock strut, with brace structure, an upper drag brace, and a linear actuating cylinder. Each is a separate line replaceable unit and is handled accordingly herein except that the linear actuating cylinder is covered in TO 9H2-2-105-3.

1-5. FUNCTION, OPERATION AND DESCRIPTION.

1-6. SHOCK STRUT. The main landing gear shock strut absorbs the energy from ground loads during landing and taxiing. This is attained by a telescoping piston and cylinder assembly that is pressurized with air and oil in the extended position. Impact loads during landing are metered by oil being forced through an orifice during the compression stroke. The taxi loads have less orifice effect and receive support from the compressed air column. On the extension stroke, a recoil valve meters oil exit between the piston and cylinder to dampen rebound loads. The shock strut cylinder also incorporates a fixed side brace to support side loads between the strut and inboard trunnion attach point. The air oil shock strut is closed system. A hydraulic interface exists with the brake pressure lines at the upper swivel manifold and lower torque arm pin. An electrical interface exists on the piston for the anti-skid lines.

1-7. The strut also has the capability of being retracted with the wheel and piston being swiveled for stowage clearance when acted upon by the retraction system. This swiveling action is accomplished by sequencing the rotary movement of the piston to the cylinder collar by torque links. The collar, in turn, is rotated by a simple link mechanism actuated by the geometry of the retract movement. In the gear down position the collar, and thereby the wheel, is locked in the forward position by a lock finger extending from the lower drag brace into a slot in both the cylinder and the collar. The initial retract motion removes the lock finger for the swivel action to rotate the wheel into the stowed position. Towing and tie down provisions are on the cylinder collar.

1-8. The shock strut assembly has an extended length of approximately 51 inches from the trunnion to the axle centerline with a compression stroke of 9 inches. It is serviced with nitrogen and hydraulic oil with the attach points being lubricated with grease.

1-9. The piston is fabricated from high-strength steel and is protected by chromium on the wear surfaces and with low-embrittlement cadmium and paint on the nonfunctional surfaces. The piston provides an axle for the wheel, brake, and anti-skid installation, and is the inner telescoping member of the shock strut. Jack pad attachment provisions are at the bottom of the piston. The left and right main gear pistons are not interchangeable.

1-10. The cylinder is fabricated from high-strength steel and is protected primarily by low embrittlement cadmium plating and paint. It is the outer fixed member of the shock strut and provides a trunnion and socket for pin attachment to the aircraft. It also incorporates an integral side brace between the inboard trunnion area and the lower end of the cylinder. The cylinder has bushed lugs for the drag and jury brace attachment, and provisions for the collar assembly. A port on the lower end of the cylinder provides for an alternate charging point as well as a drain port. Another port provides for a proximity switch to detect full extension. The left and right main gear cylinders are not interchangeable.

1-11. The orifice support tube is an anodized aluminum member that supports the hydraulic loads imposed on the orifice plate. The support tube protrudes through the top of the cylinder where it incorporates the charging port. This part is interchangeable between the left and right main gears.

1-12. The metering pin is an anodized aluminum tapered pin that meters the oil flow through the orifice and thereby controls the load stroke relationship. This pin installs against an ID bulkhead in the piston and is retained by spring-loaded pins.

1-13. The torque arm assembly consists of two high-strength steel links fastened together to maintain alignment between the cylinder, piston, and wheel. The torque arms are interchangeable between themselves and between both main gears. The torque arms also provide for the passage of brake hydraulic fluid from the hydraulic swivel at the cylinder attach point to the manifold at the piston attach point.

1-14. The torque collar mounts on the lower end of the cylinder and positions the wheel in the gear stowed and gear down position. The collar position is controlled through the swivel linkage and, in turn, positions the wheel through the torque arms that attach the collar to the piston. The collar is fabricated from high-strength steel.

1-15. Internal parts consist of seals, scraper rings, upper and lower bearings that are interchangeable between main gears. External parts consist primarily of attaching bolts and nuts fabricated from steel: they are interchangeable between main gears. There is also a hydraulic swivel that transmits the brake lines from the cylinder to the upper torque arm in order to accommodate relative rotation between the cylinder and piston during retraction.

1-16. DRAG BRACE. The drag brace supports the main gear drag loads, provides a downlock, a swivel collar forward position lock, and provides for gear retraction by folding. The interfaces with the drage brace are mechnical and consist of airframe, shock strut cylinder, swivel collar, and retract actuator attachments. The two jury links provide an overcenter downlock between the shock strut and the drag brace apex, thus preventing retraction in the extended position. Retract actuator lugs on the upper jury link provide for the energy path to unlock the jury links and retract the gear. The jury brace provides for the mounting of the ground lock pin and the downlock switch is mounted on the trunnion collar.

1-17. The upper drag brace is fabricated from titanium. The lower drag link material is high strength steel protected by cadmium. Both the upper and lower drag braces are interchangeable between the left and right main gears.

1-18. The upper jury brace is fabricated from cadmium plated, high strength steel and is not interchangeable between left and right main gears because of the actuator attachment. The lower jury brace material is anodized aluminum and is interchangeable between left and right main gears.

1-19. LEADING PARTICULARS.

1-20. Table 1-1 lists main features and leading particulars on the main landing gear assembly.

Table 1-1. Leading Particulars

Length	
Extended	51.73 to 51.87 inches
Fully Compressed	42.73 to 42.79 inches
Stroke	9.00 to 9.08 inches
Weight (approximate) (each gear)	155 pounds
Charging Medium	
Hydraulic Oil	MIL-H-5606 or MIL-H-6083
Nitrogen	BB-N-411, Type I, Class I, Grade B
Pressure Rating (fully extended)	
Low Pressure Chamber	29 to 500 psi
High Pressure Chamber	673 to 1100 psi

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STL=STEEL
AL=ALUMINUM
MAG=MAGNESIUM
TITA=TITANIUM
SS-S STL
SYN=SYNTHETIC
LD=LEAD

F-15 MAIN STRUT ASSEMBLY (L.H., H.H.W.)

BILL OF MATERIALS

26338A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE-R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	0	68A410501-2011	1620011671000	76301	F-15 MAIN STRUT ASSY (L.H., H.H.W.)	1	EA										
	.1	K410501-1003	1620011735303	30400	.KIT, PARTS (C)	1	EA										
	..2	ST7M288-122E1	5330010442339	76301	..PACKING ASSEMBLY (T-RING) (KIT)	8	EA										
	..2	7122FR160-5708	5330010442339	72902	..PACKING ASSEMBLY (T-RING)	8	EA					INT					
	..2	7122FR160T	5330010196394	72902	..PACKING ASSEMBLY (T-RING)	8	EA					INT					
	..2	ST7M254-115E1	5330010071644	76301	..PACKING ASSEMBLY (T-RING) (KIT)	12	EA										
	..2	7115MR160-5708	5330010071644	72902	..PACKING ASSYMBLY (T-RING)	12	EA					INT					
	..2	7115MR160T	5330005443259	72902	..PACKING ASSEMBLY (T-RING)	12	EA					INT					
	..2	ST7M254-113E2	5330012541395	76301	..PACKING ASSEMBLY (T-RING) (KIT)	8	EA										
	.. 2	7113MS160-5708	5330012541395	72902	..PACKING ASSEMBLY (T-RING)	8	EA					INT					
	..2	7113MS160T	5330005338134	72902	..PACKING ASSEMBLY (T-RING)	8	EA					INT					
	..2	ST7M254-119E1	5330010923186	76301	..PACKING ASSEMBLY (T-RING) (KIT)	8	EA										
	..2	7119MR160-5708	N.S.L.	72902	..PACKING ASSEMBLY (T-RING)	8						INT					
	..2	7119MR160T	5330005338137	72902	..PACKING ASSEMBLY (T-RING)	8	EA					INT					
	..2	68B418015-101	5330010808078	76301	..PACKING ASSEMBLY (T-RING) (KIT)	1	EA										
	..2	68B418015-105	5330010791953	76301	..PACKING ASSEMBLY (T-RING) (KIT)	1	EA										
	..2	68B418015-107	5330010804829	76301	..PACKING ASSEMBLY (T-RING) (KIT)	1	EA										
	..2	68B418015-103	5330010804830	76301	..PACKING ASSEMBLY (T-RING)	1	EA					INT					
	..2	68B418015-109	5330012445287	76301	..PACKING ASSEMBLY (T-RING) (KIT)	1	EA										
	..2	N.P.L.	N.S.L.		..PACKING & RETAINER ASSY (PSELJO)	1						INT					
	...3	AN6227-53	5330001965339	88044	...PACKING (O-RING)	1	EA										
	...3	MS28774-427	5330007295143	96906	...RETAINER (BACKUP RING)	1	EA										
	..2	68B418015-221	5330010800040	76301	..PACKING (T-RING) (KIT)	1	EA										
	..2	68B418015-219	5330010800039	76301	..PACKING (T-RING)	1	EA					INT					
	..2	68B418015-207	5330010800039	76301	..PACKING (T-RING)	1	EA					INT					
	..2	MS28775-332	5330006411481	96906	..PACKING (O-RING) (KIT)	1	EA										
	..2	AN6227-35	5330001943715	88044	..PACKING (O-RING)	1	EA					INT					
	..2	MS28774-332	5330005420920	96906	..RETAINER (BACKUP RING) (KIT)	1	EA										
	..2	MS28775-340	5330005822136	96906	..PACKING (O-RING) (KIT)	1	EA										
	..2	AN6227-43	5330001943730	88044	..PACKING (O-RING)	1	EA					INT					
	..2	MS28774-340	5330005821533	96906	..RETAINER (BACKUP RING) (KIT)	1	EA										
	..2	MS28775-008	5330005793158	96906	..PACKING (O-RING) (KIT)	1	EA										
	..2	MS28778-3	5330008357485	96906	..PACKING (O-RING) (KIT)	1	EA										
	..2	MS28778-4	5330008052966	96906	..PACKING (O-RING) (KIT)	1	EA										
	..2	MS28778-10	5330002859842	96906	..PACKING (O-RING) (KIT)	1	EA										
	.1	MS24665-151	5315008151405	96906	.PIN, COTTER	3	EA										
	.1	E10080-5	5310002735870	72962	.NUT, CASTLE	1	EA										
	.1	ST3M04C5	5310002735870	92592	.NUT, CASTLE	1	EA					INT					
	.1	74640C5	5310002735870	50392	.NUT, CASTLE	1	EA					INT					
	.1	AN960C516	5310001670803	88044	.WASHER, FLAT	1	EA										
STL	.1	68A410657-2001	3120003337312	76301	.BUSHING, SLEEVE (BUNGEE)	1	EA										
	.1	AN960C516L	5310001670815	88044	.WASHER, FLAT	3	EA										
	.1	MS15795-811	5310008805977	96906	.WASHER, FLAT	1	EA										
STL	.1	68B410657-1003	473C010376583	76301	.BOLT, FLUID (BUNGEE)	1	EA										

STL=STEEL
AL=ALUMINUM
MAG=MAGNESIUM
TITA=TITANIUM
SS-S STL
SYN=SYNTHETIC
LD=LEAD

F-15 MAIN STRUT ASSEMBLY (L.H., H.H.W.)

BILL OF MATERIALS

26338A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIL CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	.1	74640C6	5310003233371	50392	.NUT, CASTLE	2	EA					INT					
	.1	AN960C616L	5310001834355	88044	.WASHER, FLAT	2	EA										
STL	.1	68A410643-2001	3120003387498	76301	.BUSHING, SLEEVE (BUNGEE)	1	EA										
STL	.1	68B410056-1001	4730003650777	76301	.BOLT, FLUID (BUNGEE)	1	EA										
	.1	68A410661-1001	1620003337134	76301	.BUNGEE ASSEMBLY	1	EA										
	..2	68A410658-1001	1620010790495	76301	..CYLINDER SUBASSEMBLY	1	EA										
	...3	ST4M130-08002	3120005284353	76301	...BUSHING (BRACKET ATTACH)	2	EA										
	...3	7829418-47	3120010731960	98747	...BUSHING (BRACKET ATTACH) (O.S.)	2 AR	EA					ALT					
	...3	68A410658-2001	N.S.L.	76301	...CYLINDER	1											
	..2	68A410664-1001	N.S.L.	76301	..ROD SUBASSEMBLY	1											
	...3	NAS509-7	5310002083747	80205	...NUT, HEXAGON	1	EA										
	...3	NAS1193K7CP	5340011065436	80205	...LOCKING DEVICE (2 PCS)	1	EA										
	...3	68A410669-2001	5310003453774	76301	...NUT, EXTENSION (ROD)	1	EA										
	...3	1849A65A	5310005285893	23650	...DISC SPRING	25	EA										
	...3	68A410668-2001	5310003649593	76301	...SPACER	1	EA										
	...3	MS28775-028	5330005805056	96906	...PACKING (O-RING)	1	EA										
	...3	MS28775-015	5330006185361	96906	...PACKING (O-RING)	1	EA										
	...3	68A410662-2001	1620010783217	76301	...CAP (BUNGEE)	1	EA										
	...3	68A410665-2001	1620010777386	76301	...ROD (BUNGEE)	1	EA										
	.1	NAS6303U6H	5306005299715	80205	.BOLT, SHEAR	1	EA										
	.1	AN960C10	5310001670801	88044	.WASHER, FLAT	1	EA										
	.1	NAS679C3H	5310006809306	80205	.NUT, LOCKING	1	EA										
AL	.1	68A410616-2003	1620003337132	76301	.PLATE, LOCKING	1	EA										
AL	.1	68A410616-2001	1620003337132	76301	.PLATE, LOCKING	1	EA					INT					
	.1	E10080-4	5310002735869	72962	.NUT, CASTLE	2	EA										
	.1	ST3M404C4	5310002735869	92595	.NUT, CASTLE	2	EA					INT					
	.1	74640C4	5310002735869	50392	.NUT, CASTLE	2	EA					INT					
	.1	AN960C416L	5310005157449	88044	.WASHER, FLAT	1	EA										
STL	.1	68A410607-2001	5306004154856	76301	.BOLT, ECCENTRIC	1	EA										
	.1	E10080-7	5310003105955	72962	.NUT, CASTLE	1	EA										
	.1	ST3M40N7	5310003105955	92595	.NUT, CASTLE	1	EA					INT					
	.1	74640C7	5310003105955	50392	.NUT, CASTLE	1	EA					INT					
STL	.1	68A410632-2001	5310003768660	76301	.WASHER, KEY	1	EA										
S STL	.1	68A410625-2001	5365005403721	76301	.WASHER, LAMINATED (SHIM)	1	EA										
	.1	68A410624-1001	1620003337133	76301	.SPINDLE ASSEMBLY	1	EA										
	..2	NAS516-8A	4730002774780	80205	..FITTING, GREASE	1	EA										
	..2	N.P.L.	N.S.L.		..SPINDLE SUBASSY	1											
	...3	ST4M130-06003	3120005185104	76301	...BUSHING (LINK ATTACH)	2	EA										
	...3	7829424-65	3120010731971	98747	...BUSHING (LINK ATTACH) (O.S.)	2 AR	EA					ALT					
	...3	N.P.L.	N.S.L.		...SPINDLE	1											
S STL	.1	68A410625-2003	5365005403722	76301	.WASHER, LAMINATED (SHIM)	1	EA										
STL	.1	ST4M166-6-0035	3120003167998	76301	.BUSHING, SLEEVE (BELL CRANK)	2	EA										
STL	.1	68A410615-2001	5306003859192	76301	.BOLT, APEX	1	EA										
	.1	68A410611-1001	3040003291054	76301	.CONNECTING LINK ASSEMBLY	1	EA										
	..2	334610	4730003485328	54311	..FITTING, GREASE		EA										

12-May-89

BLDG 505/507

F-15 MAIN STRUT ASSEMBLY (L.H., H.H.W.)

BILL OF MATERIALS

26338A

STL=STEEL
AL=ALUMINUM
MAG=MAGNESIUM
TITA=TITANIUM
SS-S STL
SYN=SYNTHETIC
LD=LEAD

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	4	68M410777-2003	3120003409530	76301	....BUSHING (SPINDLE ATTACH)	1	EA										
	...3	N.P.L.	N.S.L.		...BUSHING SET (O.S.) (PSEUDO)	1	AR					ALT					
	4	7829421-63	3120010731970	98747	....BUSHING (SPINDLE ATTACH) (O.S.)	2	EA										
	...3	AS8Y6-23V	3120005299840	15860	...BEARING (SPHERICAL)	1	EA										
	...3	BSSN6-207064	3120005299840	81376	...BEARING (SPHERICAL)	1	EA					INT					
	...3	KS8Y6-17	3120005299840	97613	...BEARING (SPHERICAL)	1	EA					INT					
	...3	NSBU12ULH29A	3120005299840	21335	...BEARING (SPHERICAL)	1	EA					INT					
	...3	55927-0601	3120005299840	09455	...BEARING (SPHERICAL)	1	EA					INT					
	...3	N.P.L.	N.S.L.		...CONNECTING LINK	1											
	..2	68M410406-1003	1620003394277	76301	..CRANK ASSEMBLY	1	EA										
	..2	68M410401-1001	N.S.L.	76301	..BELLCRANK ASSEMBLY	1											
	...3	68M410442-2001	3120003387493	76301	...BUSHING (BOLT ASSY BOSS)	1	EA										
	...3	7829424-61	3120010731969	98747	...BUSHING (BOLT ASSY. BOSS) (O.S.)	1	AR EA					ALT					
	...3	7829418-03	3120010731968	98747	...BUSHING (LINK ATTACH) (REPAIR)	2	AR EA										
	...3	N.P.L.	N.S.L.		...BELLCRANK	1											
	..2	NAS6307U33D	5306005300005	80205	..BOLT, SHEAR	1	EA										
	..2	AN960C716	5310001670805	88044	..WASHER, FLAT	2	EA										
	..2	E10080-7	5310003105955	72962	..NUT, CASTLE	1	EA										
	..2	ST3M404C7	5310003105955	92595	..NUT, CASTLE	1	EA					INT					
	..2	74640C7	5310003105955	50392	..NUT, CASTLE	1	EA					INT					
	..2	MS24665-300	5315002341863	96906	..PIN, COTTER	1	EA										
	..2	[redacted]	N.S.L.	76301	..BOLT ASSY SEV (CRANK)	1											
	...3	ST4M13-08002	3120005284353	76301	...BUSHING (BUNGEE ATTACH)	2	EA										
	...3	7829424-67	3120010731941	98747	...BUSHING (BUNGEE ATTACH) (O.S.)	2	AR EA					ALT					
	...3	N.P.L.	N.S.L.		...BOLT (CRANK)	1											
SYN	.1	68M410408-1001	1620003394294	76301	.INSERT, LUBRICATION (PLASTIC)	1	EA										
	.1	MS15002-1	4730001720010	96906	.FITTING, GREASE	1	EA										
	.1	MS28775-018	5330006180799	96906	.PACKING (O-RING)	1	EA										
	.1	MS28775-023	5330006896460	96906	.PACKING (O-RING)	1	EA										
	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]										
	..2	MS516-1A	4730002774780	80205	..FITTING, GREASE	1	EA										
	..2	N.P.L.	N.S.L.		..PIN (JURY LINK ATTACH)	1											
	.1	NAS6304U32D	5306005285032	80205	.BOLT, SHEAR	1	EA										
	.1	AN960C416L	5310011215534	88044	.WASHER, FLAT	2	EA										
	.1	E10080-10	5310003105979	72962	.NUT, CASTLE	1	EA										
	.1	ST3M404C10	5310003105979	92595	.NUT, CASTLE	1	EA					INT					
	.1	74640C10	5310003105979	50392	.NUT, CASTLE	1	EA					INT					
	.1	MS24665-302	5315002341864	96906	.PIN, COTTER	1	EA										
	.1	AN960C1016L	5310002826907	88044	.WASHER, FLAT	1	EA										
SYN	.1	4M36-0028	5310010990546	76301	.WASHER, FLAT (SPECIAL)	1	EA										
	.1	AN960C1216L	5310005955607	88044	.WASHER, FLAT	1	EA										
STL	.1	4M46-12-15	3120004359025	76301	.BUSHING, SLEEVE (BOLT)	1	EA										
STL	.1	68M10719-1001	1620003386550	76301	.BOLT ASSEMBLY (RETRACT)	1	EA										
	..2	MS516-1A	4730002774780	80205	..FITTING, GREASE	1	EA										

STL=STEEL
AL=ALUMINUM
MAG=MAGNESIUM
TITA=TITANIUM
SS-S STL
SYN=SYNTHETIC
LD=LEAD

F-15 MAIN STRUT ASSEMBLY (L.H., H.H.W.)

BILL OF MATERIALS

26338A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	...3	NAS51601A	4730002774780	80205	...FITTING, GREASE	2	EA										
	...3	N.P.L.	N.S.L.		...BRACE SUBASSY, LOWER DRAG	1											
	4	N.P.L.	N.S.L.		....BUSHING SET (PSEUDO)	1											
	5	ST4M130-22005	3120005284362	76301	.....BUSHING (LINK ATTACH)	2	EA										
	5	ST4M130-22003	3120005284774	76301	.....BUSHING (LINK ATTACH)	2	EA										
	4	N.P.L.	N.S.L.		....BUSHING, SET (O.S.) (PSEUDO)	1	AR					ALT					
	5	7829424-55	3120010740292	98747	.....BUSHING (LINK ATTACH) (O.S.)	2	EA										
	5	7829424-53	3120010731966	98747	.....BUSHING (LINK ATTACH) (O.S.)	2	EA										
	4	ST4M13?-22004	3120005185630	76301	....BUSHING (CRANK BOLT BOSS)	2	EA										
	4	78294? 57	3120010731967	98747	....BUSHING (CRANK BOLT BOSS) (O.S.)	2	AR	EA				ALT					
	4	68A410?87-2001	1620003337135	76301	....SLEEVE (DRAG BRACE LOCK)	1	EA										
	4	NAS1199-5-20	5320005262959	80205	....RIVET	1	EA										
	4	N.P.L.	N.S.L.		....BRACE (LOWER DRAG)	1											
	..2	MS24665-153	5315002341854	96906	..PIN, COTTER	7	EA										
	..2	74384-5M	N.S.L.		..NUT, CASTLE	2											
STL	..2	68A410779-2001	1620003480778	76301	..ADAPTER (LOWER LINK)	2	EA										
STL	..2	68A410780-2001	5307003900753	76301	..STUD (LOWER LINK)	1	EA										
STL	..2	68A410755-2005	1620003337138	76301	..PIN, APEX	1	EA										
	..2	E10080-5	5310002735870	72962	..NUT, CASTLE	2	EA										
	..2	ST3M404C5	5310002735870	92595	..NUT, CASTLE	2	EA					INT					
	..2	74640C5	5310002735870	50392	..NUT, CASTLE	2	EA					INT					
	..2	AN960C516L	5310001670814	88044	..WASHER, FLAT	4	EA										
AL	..2	68A410791-2001	3120005461885	76301	..BUSHING (SPRING ATTACH)	2	EA										
STL	..2	ST4M167P5-0095	3120005515139	76301	..BEARING (INNER SLEEVE)	2	EA										
STL	..2	4M36-02087	N.S.L.	76301	..WASHER, FLAT (SPECIAL)	2											
	..2	NAS6305U16D	5306006151585	80205	..BOLT, SHEAR	2	EA										
	..2	E10080-4	5310002735869	72962	..NUT, CASTLE	2	EA										
	..2	ST3M404C4	5310002735869	92595	..NUT, CASTLE	2	EA					INT					
	..2	74640C4	5310002735869	50392	..NUT, CASTLE	2	EA					INT					
STL	..2	4M36-02084	N.S.L.	76301	..WASHER, FLAT (SPECIAL)	2											
SYN	..2	68A410782-2003	1620005389940	76301	..SPOOL (LINKAGE SPACER)	2	EA										
STL	..2	68A410780-2003	5315005596141	76301	..STUD (UPPER LINK)	1	EA										
	..2	68A410725-1005	1620012249329	76301	..SPRING ASSY, DOWNLOCK (L.H.)	1	EA										
	...3	MB1934/1-05C016	3120012106190	81349	...BUSHING, FABROID	1	EA										
	...3	MB1934/1-07C018	N.S.L.	81349	...BUSHING, FABROID	1											
	...3	N.P.L.	N.S.L.		...SPRING, DOWNLOCK (L.H.)	1											
	..2	68A410725-1003	N.S.L.	76301	..SPRING ASSY, DOWNLOCK (L.H.)	1						SUB					
	...3	MB1934/1-05C016	3120012106190	81349	...BUSHING, FABROID	1	EA										
	...3	MB1934/1-07C018	N.S.L.	81349	...BUSHING, FABROID	1											
	...3	N.P.L.	N.S.L.		...SPRING, DOWNLOCK (L.H.)	1											
	..2	68A410725-1001	1620001323253	76301	..SPRING ASSY, DOWNLOCK (L.H.)	1	EA					INT					
	...3	MB1934/1-05C016	3120012106190	81349	...BUSHING, FABROID	1	EA										
	...3	MB1934/1-07C018	N.S.L.	81349	...BUSHING, FABROID	1											
	...3	N.P.L.	N.S.L.		...SPRING, DOWNLOCK (L.H.)	1											

12-May-82

BLDG 505/507

STL=STEEL
AL=ALUMINUM
MAG=MAGNESIUM
TITA=TITANIUM
SS-S STL
SYN=SYNTHETIC
LD=LEAD

F-15 MAIN STRUT ASSEMBLY (L.H., H.H.W.)

BILL OF MATERIALS

26338A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	..2	68A410725-1004	1620001323209	76301	..SPRING ASSY, DOWNLOCK (R.H)	1	EA					SUB					
	...3	MB1934/1-05C016	3120012106190	81349	...BUSHING, FABROID	1	EA										
	...3	MB1934/1-07C018	N.S.L.	81349	...BUSHING, FABROID	1											
	...3	N.P.L.	N.S.L.		...SPRING, DOWNLOCK (R.H.)	1											
	..2	68A410725-1002	1620001323209	76301	..SPRING ASSY, DOWNLOCK (R.H.)	1	EA					INT					
	...3	MB1934/1-05C016	3120012106190	81349	...BUSHING, FABROID	1	EA										
	...3	MB1934/1-07C018	N.S.L.	81349	...BUSHING, FABROID	1											
	...3	N.P.L.	N.S.L.		...SPRING, DOWNLOCK (R.H.)	1											
STL	..2	68A410771-2001	5310005570517	04274	..NUT, APEX (SPECIAL)	1	EA										
STL	..2	68A410770-1001	4730005487352	76301	..BOLT ASSY, APEX (JURY LINK)	1	EA										
	...3	NAS516-1A	4730002774780	80205	...FITTING, GREASE	1	EA										
	...3	N.P.L.	N.S.L.		...BOLT, APEX (JURY LINK)	1											
STL	..2	68A410764-2001	5315005546340	76301	..PIN, APEX (JURY LINK)	1	EA										
	..2	68A410795-1003	1620010360263	76301	..LINK ASSEMBLY (LOWER JURY)	1	EA										
	...3	NAS516-1A	4730002774780	80205	...FITTING, GREASE	1	EA										
	...3	N.P.L.	N.S.L.		...LINK SUBASSY, (LOWER JURY)	1											
	4	ST4M130-10006	3120005260517	76301	....BUSHING (APEX BOSS)	2	EA										
	4	17829424-51	3120010731963	98747	....BUSHING (APEX BOSS) (O.S.)	2	AR EA					ALT					
	4	68A410778-2001	3120005063232	76301	....BUSHING (DRAG BRACE ATTACH)	1	EA										
	4	17829419-01	3120010746917	98747	....BUSHING (DRAG BRACE ATTACH) (O.S.	1	AR EA					ALT					
	4	17829423-27	3120010731964	98747	....BUSHING (GROUND BOSS) (REPAIR)	2	AR EA										
	4	N.P.L.	N.S.L.		....LINK (LOWER JURY)	1											
	..2	68A410774-1005	1620010403581	76301	..LINK ASSEMBLY (UPPER JURY)	1	EA										
	...3	NAS516-1A	4730002774780	80205	...FITTING, GREASE	1	EA										
	...3	N.P.L.	N.S.L.		...LINK SUBASSY (UPPER JURY)	1											
	4	MB1936-1-12	3120010388753	81349	....BEARING, SPHERICAL	1	EA										
	4	ST4M130-10006	3120005260517	76301	....BUSHING (APEX BOSS)	2	EA										
	4	17829424-51	3120010731963	98747	....BUSHING (APEX BOSS) (O.S.)	2	AR EA					ALT					
	4	17829423-23	3120010731961	98747	....BUSHING (JURY LINK PIN BOSS) (RPR)	1	AR EA										
	4	N.P.L.	N.S.L.		....LINK (UPPER JURY)	1											
	.1	68A410700-1007	N.S.L.	6301	.SHOCK ABSORBER ASSY (L.H., H.H.W.)	1											
	..2	MS24391-4	5365008051403	96906	..PLUG, MACHINE	1	EA										
	..2	MS24391D10L	5365009000972	96906	..PLUG, MACHINE	1	EA										
	..2	MS28889-2	4820005356483	96906	..VALVE ASSEMBLY (CHARGING)	3	EA										
	..2	MS24391D3L	5365000068202	96906	..PLUG, MACH	1	EA										
AL	..2	68A410730-2001	N.S.L.	76301	..NUT, SPECIAL ...FICE TUBE)	1											
STL	..2	68A410720-2003	5310010668661	76301	..NUT, SPECIAL (ORIFICE TUBE)	1	EA					SUB					
STL	..2	68A410719-2003	N.S.L.	76301	..RETAINER (ORIFICE TUBE)	1											
STL	..2	68A410719-2001	5330004869596	76301	..RETAINER (ORIFICE TUBE)	1	EA					SUB					
STL	..2	68A410674-2001	1620000386551	76301	..TAB, LOCKING (GLAND NUT)	1	EA										
	..2	MS6304H6	5306002837462	80205	..BOLT, SHEAR	4	EA										
	..2	MS9620H16	5310009520309	80205	..WASHER, FLAT	4	EA										
	..2	MS9679H4	5310007207644	80205	..NUT, LOCKING	6	EA										
	..2	68A890030-2001	N.S.L.	76301	..PLATE, IDENTIFICATION	1											

STL=STEEL
AL=ALUMINUM
MAG=MAGNESIUM
TITA=TITANIUM
SS=S STL
SYN=SYNTHETIC
LD=LEAD

F-15 MAIN STRUT ASSEMBLY (L.H., H.H.W.)

BILL OF MATERIALS

26338A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	..2	ST3M404C4	5310002735869	92595	..NUT, CASTLE	2	EA					INT					
	..2	74640C4	5310002735869	50392	..NUT, CASTLE	2	EA					INT					
	..2	MS24665-151	5315008151405	96906	..PIN, COTTER	4	EA										
	..2	E10080-5	5310002735870	72962	..NUT, CASTLE	2	EA										
	..2	ST3M404C5	5310002735870	92595	..NUT, CASTLE	2	EA					INT					
	..2	74640C5	5310002735870	50392	..NUT, CASTLE	2	EA					INT					
STL	..2	68A410X22-2001	5310003453822	76301	..WASHER, SPECIAL (SWIVEL)	2	EA										
S STL	..2	68A410X19-1001	1620003394341	76301	..SHAFT ASSEMBLY (HYDRAULIC SWIVEL)	1	EA										
	...3	MS16555-602	5315008487829	96906	...PIN, SPRING (ROLL)	1	EA										
STL	...3	RF5004-13	4730002706240	83324	...ADAPTER, FLUID	1	EA										
	...3	MS28775-010	5330005840266	96906	...PACKING (O-RING)	1	EA										
STL	...3	RF5006-13	4730002706241	83324	...ADAPTER, FLUID	1	EA										
	...3	MS28775-012	5330005840265	96906	...PACKING (O-RING)	1	EA										
	...3	N.P.L.	N.S.L.		...SHAFT (HYDRAULIC SWIVEL)	1											
AL	..2	68A410614-1003	1620003394338	76301	..LINK (HYDRAULIC TRANSFER)	1	EA										
	..2	NAS6304U1H	5306005084173	80205	..BOLT, SHEAR	1	EA										
STL	..2	68A410653-2001	5310003572449	76301	..WASHER, SPECIAL (SWIVEL)	1	EA										
S STL	..2	68A410621-1005	1620003394377	76301	..CRANK ASSEMBLY (HYD TRANSFER)	1	EA										
	...3	MS16556-802	5315011027480	96906	...PIN, SPRING (ROLL)	2	EA										
	...3	N.P.L.	N.S.L.		...CRANK (HYD TRANSFER)	1											
STL	..2	68141064O-1001	1620003394300	76301	..PIN, TORQUE ARM	2	EA										
	..2	N.P.L.	N.S.L.		..BOLT & WASHER ASSY (PSEUDO)	2											
	...3	NAS6304U4	5306004922584	80205	...BOLT, SHEAR	1	EA										
	...3	AN960C416	5310005319515	88044	...WASHER, FLAT	1	EA										
	..2	N.P.L.	N.S.L.		..BOLT & WASHER ASSY (PSEUDO)	2	AR					ALT					
	...3	BM17019-4-4X	5306010442963	08524	...BOLT, SHEAR (1ST O.S.)	1	EA										
	...3	AN960C416	5310005319515	88044	...WASHER, FLAT	1	EA										
	..2	N.P.L.	N.S.L.		..BOLT & WASHER ASSY (PSEUDO)	2	AR					INT					
	...3	MB88-4-4	5306010442963	73197	...BOLT, SHEAR (1ST O.S.)	1	EA										
	...3	AN960C416	5310005319515	88044	...WASHER, FLAT	1	EA										
	..2	N.P.L.	N.S.L.		..BOLT & WASHER ASSY (PSEUDO)	2	AR					INT					
	...3	PBF1254-4-4	N.S.L.	27624	...BOLT, SHEAR (1ST O.S.)	1											
	...3	AN960C416	5310005319515	88044	...WASHER, FLAT	1	EA										
	..2	N.P.L.	N.S.L.		..BOLT & WASHER ASSY (PSEUDO)	2	AR					INT					
	...3	S11-106-4-4	N.S.L.	57928	..BOLT, SHEAR (1ST O.S.)	1											
	...3	AN960C416	5310005319515	88044	..WASHER, FLAT	1	EA										
	..2	N.P.L.	N.S.L.		..BOLT & WASHER ASSY (PSEUDO)	2	AR					INT					
	...3	VAL2360-4-4	5306010442963	06710	...BOLT, SHEAR (1ST O.S.)	1	EA										
	...3	AN960C416	5310005319515	88044	...WASHER, FLAT	1	EA										
	..2	N.P.L.	N.S.L.		..BOLT & WASHER ASSY (PSEUDO)	2	AR					INT					
	...3	VS3037-4-4	5306010442963	92215	...BOLT, SHEAR (1ST O.S.)	1	EA										
	...3	AN960C416	5310005319515	88044	...WASHER, FLAT	1	EA										
	..2	N.P.L.	N.S.L.		..BOLT & WASHER ASSY (PSEUDO)	2	AR					INT					
	...3	109430-4-4	N.S.L.	03680	...BOLT, SHEAR (1ST O.S.)	1											
	...3	AN960C416	5310005319515	88044	...WASHER, FLAT	1	EA										

STL=STEEL
AL=ALUMINUM
MAG=MAGNESIUM
TITA=TITANIUM
SS-S STL
SYN=SYNTHETIC
LD=LEAD

F-15 MAIN STRUT ASSEMBLY (L.H., H.H.W.)

BILL OF MATERIALS

26338A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	..2	N.P.L.	N.S.L.		..BOLT & WASHER ASSY (PSEUDO)	2	AR					INT					
	...3	MB89-4-4	5306010452871	73197	...BOLT, SHEAR (2ND O.S.)	1	EA										
	...3	AN960C516	5310001670803	88044	...WASHER, FLAT	1	EA										
	..2	N.P.L.	N.S.L.		..BOLT & WAHSER ASSY (PSEUDO)	2	AR					INT					
	...3	B11-1062-4-4	N.S.L.	57928	...BOLT, SHEAR (2ND O.S.)	1											
	...3	AN960C516	5310001670803	88044	...WAHSER, FLAT	1	EA										
	..2	N.P.L.	N.S.L.		..BOLT & WASHER ASSY (PSEUDO)	2	AR					INT					
	...3	VAL23608-4-4	5306010452871	06710	...BOLT, SHEAR (2ND O.S.)	1	EA										
	...3	AN960C516	5310001670803	88044	...WASHER, FLAT	1	EA										
	..2	N.P.L.	N.S.L.		..BOLT & WASHER ASSY (PSEUDO)	2	AR					INT					
	...3	VS3038-4-4	5306010452871	92215	...BOLT, SHEAR (2ND O.S.)	1	EA										
	...3	AN960C516	5310001670803	88044	...WASHER, FLAT	1	EA										
	..2	N.P.L.	N.S.L.		..BOLT & WASHER ASSY (PSEUDO)	2	AR					INT					
	...3	109451-4-4	N.S.L.	03680	...BOLT, SHEAR (2ND O.S.)	1											
	...3	AN960C516	5310001670803	88044	...WASHER, FLAT	1	EA										
STL	..2	68A410620-2003	1620004881770	76301	..MANIFOLD (UPPER)	1	EA										
AL	..2	68A410651-1001	1620003394301	76301	..MANIFOLD ASSY (LOWER)	1	EA										
STL	...3	RF5006-13	4730002706241	83324	...ADAPTER, FLUID	1	EA										
	...3	MS28775-012	5330005840265	96906	...PACKING (O-RING)	1	EA										
STL	...3	RF5004-13	4730002706240	83324	...ADAPTER, FLUID	1	EA										
	...3	MS28775-010	5330005840266	96906	...PACK..G (O-RING)	1	EA										
	...3	N.P.L.	N.S.L.		...MANIFOLD (LOWER)	1											
	..2	MS24665-372	5315000590491	96906	..PIN, COTTER	1	EA										
STL	..2	68A410654-2001	5310003952927	76301	..NUT, SPECIAL (APEX)	1	EA										
STL	..2	68A410656-2001	5310003440092	76301	..WASHER, KEY (APEX)	1	EA										
BRASS	..2	68A410655-2001	5310003856022	76301	..WASHER, SPACER (APEX)	4	EA										
SS STL	..2	68A410652-1001	1620003480794	76301	..BOLT, SPECIAL (APEX)	1	EA										
	..2	68A410646-2005	1620001386306	76301	..ARM, TORQUE	2	EA										
STL	..2	68A410649-2001	5310003464801	76301	..NUT, ROUND (TORQUE COLLAR)	1	EA										
STL	..2	68A410673-2001	1620003440615	76301	..WASHER, KEYING (COLLAR NUT)	1	EA										
	..2	68A410733-1001	1620003440616	76301	..COLLAR ASSEMBLY (TORQUE)	1	EA										
	...3	NAS516-1A	4730002774780	80205	...FITTING, GREASE	4	EA										
	...3	N.P.L.	N.S.L.		...COLLAR SUBASSY (TORQUE	1											
	4	N.P.L.	N.S.L.		....BUSHING SET (PSEUDO)	1											
	5	68A410644-2001	5365005127579	76301	.....BUSHING (COLLAR BOTTOM)	1	EA										
	5	68A410645-2003	1620005546589	76301	.....BUSHING (COLLAR TOP)	1	EA										
	4	N.P.L.	N.S.L.		....BUSHING SET (O.S.)(PSEUDO)	1	AR					ALT					
	5	7829424-89	3120010731981	98747	.....BUSHING (COLLAR BOTTOM)(O.S.)	1	EA										
	5	7926302-01	N.S.L.	98747	.....BUSHING (COLLAR TOP)(O.S.)	1											
	4	N.P.L.	N.S.L.		....BUSHING SET (PSEUDO)	1											
	5	ST4M130-10001	3120005442961	76301	.....BUSHING (SPINDLE LUG, BOTTOM)	1	EA										
	5	ST4M130-98003	3120005284772	76301	.....BUSHING (SPINDLE LUG, TOP)	1	EA										
	4	N.P.L.	N.S.L.		....BUSHING SET (O.S.)(PSEUDO)	1	AR					ALT					
	5	7829424-85	3120010731980	98747	.....BUSHING(SPINDLE LUG,BTM)(O.S.)	1	EA										
	5	7829424-83	3120010740293	98747	.....BUSHING(SPINDLE LUG, TOP)(O.S.)	1	EA										

STL=STEEL
AL=ALUMINUM
MAG=MAGNESIUM
TITA=TITANIUM
SS-6 STL
SYN=SYNTHETIC
LD=LEAD

F-15 MAIN STRUT ASSEMBLY (L.H., H.H.W.)

BILL OF MATERIALS

26338A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
	..2	68A410638-1009	1620010753563	76301	..COLLAR ASSEMBLY (TRUNNION)	1	EA										
	...3	68A410638-2021	N.S.L.	76301	...COLLAR ASSY, HALF (UPPER)	1											
	4	68A410638-2005	N.S.L.	76301	....COLLAR, HALF (UPPER) (MACH.)	1											
	...3	NAS6304U7	5306003219052	80205	...BOLT, SHEAR	2	EA										
	...3	AN960C416	5310005319515	88044	...WASHER, FLAT	2	EA										
	...3	NAS679C4W	5310007207644	80205	...NUT, LOCKING	4	EA										
	...3	NAS1304-31	5306008512612	80205	...BOLT, MACHINE	2	EA										
	...3	AN960C416L	5310005157449	88044	...WASHER, FLAT	12	EA										
	...3	NAS1056C8-030	5365010663987	80205	...SPACER, SLEEVE	2	EA										
	...3	NAS516-1A	4730002774780	80205	...FITTING, GREASE	2	EA										
	...3	NAS516-1	4730002774780	80205	...FITTING, GREASE	2	EA					INT					
	...3	68A410638-2019	N.S.L.	76301	...COLLAR ASSEMBLY (HALF) (LOWER)	1											
	4	ST4M139C6-23	3120005087441	76301	....BUSHING (ACTUATOR ATTACH)	2	EA										
	4	7B2924-93	N.S.L.	98747	....BUSHING (ACTUATOR ATTACH) (O.S)	2	AR					ALT					
	4	7B29423-33	3120010731974	98747	....BUSHING (BUNGEE ATTACH) (REPAIR)	2	AR	EA									
	4	68A410638-2003	N.S.L.	76301	....COLLAR, HALF (LOWER) (MACH.)	1											
BRASS	..2	68A410692-2007	3120010761599	76301	..BUSHING (TRUNNION COLLAR)	2	EA										
BRASS	..2	7B29422-01	3120010732297	98747	..BUSHING (TRUNNION COLLAR) (O.S.)	2	AR	EA				ALT					
	..2	68A410691-2005	1620010950952	76301	..PLATE, STOP (TRUNNION COLLAR)	2	EA										
	..2	68A410735-2001	1620003386529	76301	..PIN, TRUNNION	1	EA										
	..2	NAS6306U46	5306010483250	80205	..BOLT, SHEAR	1	EA										
	..2	AN960C616	5310001670804	88044	..WASHER, FLAT	1	EA										
	..2	NAS679C6	5310006809297	80205	..NUT, LOCKING	1	EA										
	..2	9M100-7	7690009375842	76301	..PLATE, AGE CONTROL	1	EA										
	..2	68A890034-2011	N.S.L.	76301	..PLATE, INSTRUCTION	1											
	..2	68A890033-2001	N.S.L.	76301	..PLATE, INSTRUCTION & IDENTIFICATIO	1											
	..2	68A410702-1005	1620010760547	76301	..CYLINDER ASSEMBLY (OUTER)	1	EA										
	...3	68A410720-2001	3120003654782	76301	...BUSHING (TRUNNION BOSS)	1	EA										
	...3	7B829417-01	N.S.L.	98747	...BUSHING (TRUNNION BOSS) (O.S.)	1	AR					ALT					
	...3	68A410670-2001	3120003481530	76301	...BUSHING (DOOR DRIVE)	6	EA										
	...3	7B29424-37	3120010734682	98747	...BUSHING (DOOR DRIVE) (O.S.)	6	AR	EA				ALT					
	...3	N.P.L.	N.S.L.		...BUSHING SET (PSEUDO)	1											
	4	ST4M130-16001	3120005260522	76301	....BUSHING (UPPER JURY LINK O.B.)	1	EA										
	4	ST4M130-20001	3120005284361	76301	....BUSHING (UPPER JURY LINK I.B.)	1	EA										
	...3	N.P.L.	N.S.L.		...BUSHING SET (O.S.) (PSEUDO)	1	AR					ALT					
	4	7B29424-81	3120010731979	98747	....BUSHING (UP JURY LINK O.B.) (O/S)	1	EA										
	4	7B29424-77	3120010731978	98747	....BUSHING (UP JURY LINK I.B.) (O/S)	1	EA										
	...3	ST4M130-22002	3120005197248	76301	...BUSHING (UPPER DRAG)	4	EA										
	...3	7B29424-75	3120010731976	98747	...BUSHING (UPPER DRAG) (O.S)	4	AR	EA				ALT					
	...3	N.P.L.	N.S.L.		...BUSHING & PACKING ASSY (PSEUDO)	1	AR										
	4	LE110-3	3120012056336	76301	...BUSHING (ORIFICE TUBE) (REPAIR)	1	EA										
	4	MS28775-149	5330008824963	96906	...PACKING (O-RING) (REPAIR)	1	EA										
	...3	68A410701-2005	N.S.L.	76301	...CYLINDER (OUTER)	1											
STL	..2	68A410660-2001	5365004249388	76301	..RING, RETAINING (AXLE NUT)	1	EA										

STL=STEEL
AL=ALUMINUM
MAG=MAGNESIUM
TITA=TITANIUM
SS-S STL
SYN=SYNTHETIC
LD=LEAD

F-15 MAIN STRUT ASSEMBLY (L.H., H.H.W.)

BILL OF MATERIALS

26338A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH JRD CHG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
AL	..2	68A7531248-48BA	1620010749060	76301	..CABLE ASSEMBLY (ELECTRICAL)	1	EA										
	...3	MS27472T10F5P	5935005039701	96906	...CONNECTOR, RECEP	1	EA										
	4	M39029/4-20-20	5999001468592	81349	....PIN	5	EA										
	...3	MS27473T10F5S	5935005588284	96906	...CONNECTOR, PLUG	1	EA										
	4	M39029/5-20-20	5999001728253	81349	....SOCKET	5	EA										
	...3	68A890017-3274	9905010820574	76301	...BAND, MARKER	1	FA										
	...3	68A890017-3275	N.S.L.	76301	...BAND, MARKER	1											
	...3	AN960-C4	5310011416672	88044	...WASHER, FLAT	4	EA										
	...3	MS51957-121	5305004008531	96906	...SCREW, MACHINE	4	EA										
	...3	NAS679C04M	5310008034663	80205	...NUT, SELF LOCK	4	EA										
	...3	68A411760-1001	1620003486494	76301	...ADAPTER, LANDING	1	EA										
	...3	MS27505F10-2	5935005519501	96906	...CABLE, CLAMP	1	EA										
	...3	ST5M1308F10-1	5935005409540	76301	...CABLE, CLAMP	1	EA										
	...3	ST5M1278-20S2U0	N.S.L.	76301	...CABLE, SPECIAL (TWO FEET)	2											
	...3	M27500-20SA2U00	6145011014898	81349	...CABLE, SPECIAL (TWO FEET)	2	EA					SUB					
STL	..2	68B410061-1001	1310003481526	76301	..CAM FOLLOWER ASSEMBLY	1	EA										
	...3	NAS516-1A	4730002774780	80205	...FITTING, GREASE	1	EA										
	...3	N.P.L.	N.S.L.		...CAM, FOLLOWER	1											
	..2	MS24665-300	5315002341863	96906	..PIN, COTTER	1	FA										
	..2	E10080-8	N.S.L.	72962	..NUT, CASTLE	1											
	..2	ST3M404C8	N.S.L.	92595	..NUT, CASTLE	1						INT					
	..2	74640C8	N.S.L.	50392	..NUT, CASTLE	1						INT					
	..2	AN960C816	5310001670806	88044	..WASHER, FLAT	3	EA										
S STL	..2	4M38C816L	5365007280923	76301	..WASHER, LAMINATED (SHIM)	2	EA										
BRASS	..2	68A410784-2003	5315001245344	76301	..PIN, HEADED STRAIGHT	2	EA										
	..2	68A410704-1011	1620010803404	76301	..PISTON ASSEMBLY	1	EA										
	...3	NAS516-1A	4730002774780	80205	...FITTING, GREASE	2	EA										
	...3	N.P.L.	N.S.L.		...PISTON SUBASSEMBLY	1											
	4	ST4M130-08005	3120005185629	76301	....BUSHING (CAM FOLLOWER)	2	EA										
	4	7829424-71	3120010731973	98747	....BUSHING(CAM FOLLOWER)(O.S.)	2 AR	EA					ALT					
	4	68A410636-2001	3120003481527	76301	....BUSHING (TORQUE ARM)	2	EA										
	4	7829421-01	3120010731972	98747	....BUSHING (TORQUE ARM)(O.S.)	2 AR	EA					ALT					
	4	68A410704-2004	N.S.L.	76301	....PISTON	1											
AL/SYN	4	79287	1620003959764	09455	....HEAD (UPPER BEARING)	1	EA										
	...3	N.P.L.	N.S.L.		...PISTON SUBASSEMBLY	1						INT					
	4	ST4M130-08005	3120005185629	76301	....BUSHING (CAM FOLLOWER)	2	EA										
	4	7829424-71	3120010731973	98747	....BUSHING (CAM FOLLOWER)(O.S.)	2 AR	EA					ALT					
	4	68A410636-2001	3120003481527	76301	....BUSHING (TORQUE ARM)	2	EA										
	4	7829421-01	3120010731972	98747	....BUSHING (TORQUE ARM)(O.S.)	2 AR	EA					ALT					
	4	68A410704-2017	N.S.L.	76301	....PISTON	1											
AL/SYN	4	79287	1620003959764	09455	....HEAD (UPPER BEARING)	1	EA										
AL	..2	68A410735-2003	1620001238987	76301	..STAND PIPE (ORIFICE TUBE)	1	EA										
	..2	68A410790-2001	1620003654003	76301	..PISTON, HIGH PRESSURE	1	EA										
	..2	68A410726-1001	1620003486485	76301	..TUBE ASSEMBLY (ORIFICE TUBE)	1	EA										

STL=STEEL
AL=ALUMINUM
MAG=MAGNESIUM
TITA=TITANIUM
SS=S STL
SYN=SYNTHETIC
LD=LEAD

S-1S MAIN STRUT ASSEMBLY (L.H., H.H.W.)

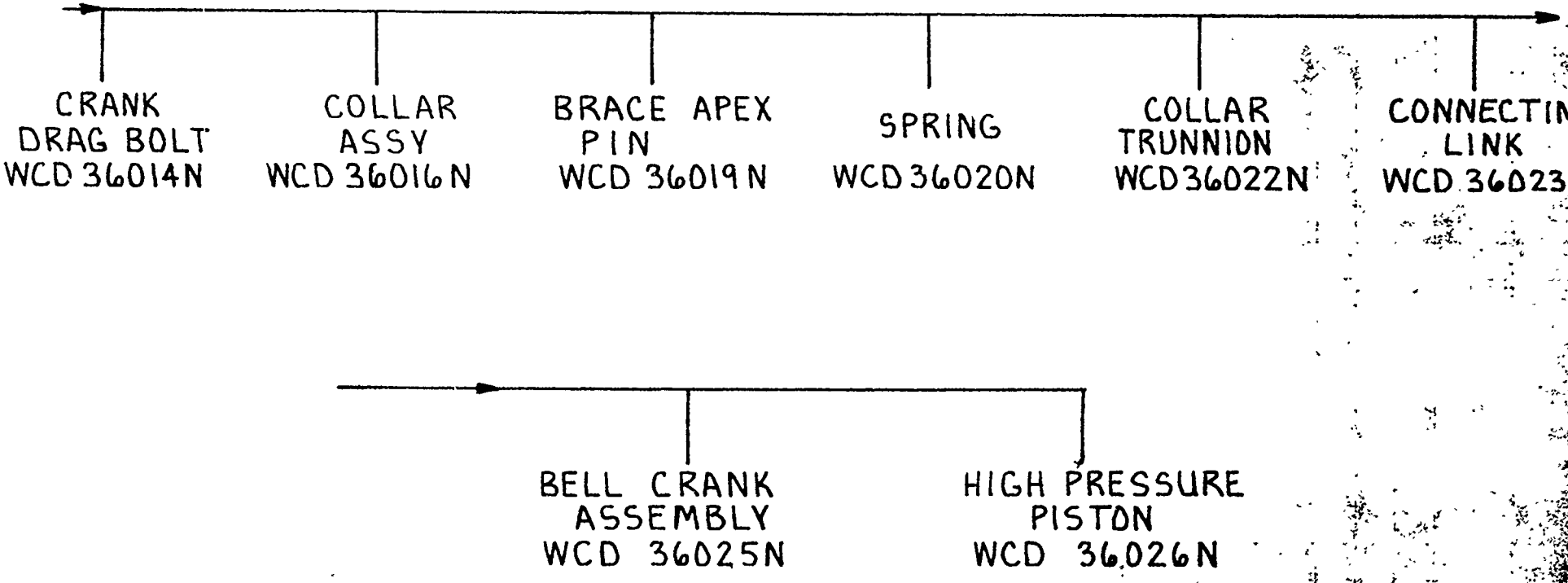
BILL OF MATERIALS

26338A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT OF MEAS	YIELD RATE	SCRAP FACTOR	PART TYPE R,D,C	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD CNG NUMBER	PENDING 103 ACTION	PENDING 252 ACTION	PENDING AFTO 22 ACTION
STL	..2	68A410727-2001	1620003959754	76301	..RING, PISTON	.1	EA										
AL	..2	68A410723-1001	4730003547633	76301	..RESTRICTOR, FLOW	1	EA										
AL	..2	68A410631-2001	1620005006802	76301	..TAB, LOCKING	1	EA										
	..2	NAS1351C3H4	5305003726315	80205	..SCREW, MACHINE	2	EA										
AL	..2	68A410713-2003	1620010667227	76301	..PIN, METERING	1	EA										
	..2	RRT16SCD-M9	5365011232480	80756	..RING, RETAINING	1	EA										
AL	..2	68A410742-2001	1620010703436	76301	..CAP (METERING PIN)	1	EA										
	..2	RST93CJ-M9	5365010986662	80756	..RING, RETAINING	1	EA										
	..2	RST93SP-M9	N.S.L.		..RING, RETAINING	.1						INT					
AL	..2	68A410740-2001	1620010703435	76301	..LOCK ADAPTER (METERING PIN)	1	EA										
STL	..2	68A410741-2001	5360010768450	76301	..SPRING, COMPRESSION	1	EA										
BRASS	..2	68A410X28-2003	5315011963425	76301	..PIN, LOCKING (METERING PIN)	3	EA										
BRASS	..2	68A410X28-2001	5315003770964	76301	..PIN, LOCKING (METERING PIN)	3	EA					INT					
	..2	68A410788-2003	5315005389262	76301	..PIN, LOCKING (POSITION RING)	1	EA										
STL	..2	68A410798-2003	1620005357468	76301	..RETAINER (SNUBBER STOP)	1	EA										
STL	..2	68A410797-2001	5365005264500	76301	..RING, POSITIONING (SNUBBER STOP)	1	EA										
STL	..2	68A410796-2001	1620005233927	76301	..STOP, SNUBBER	1	EA										
STL	..2	68A410705-1005	N.S.L.	76301	..DAMPENER, REBOUND (PRESSURE)	1											
STL	..2	68A410705-1007	N.S.L.	76301	..DAMPENER, REBOUND (PRESSURE)	1						SUB					
AL	..2	68A410641-2001	5330003900259	76301	..RETAINER, SEAL	1	EA										
AL	..2	79288	3120004168900	09455	..BEARING, LOWER	1	EA										
BRASS	..2	MS28776-2-41	1650005168336	96906	..RING, SCRAPER	1	EA										
AL	..2	68A410618-2001	4730003650242	76301	..NUT, GLAND (PACKING)	1	EA										
	.1	NAS817-4	5340006822113	80205	.CAP, PROTECTIVE	2	EA										
	.1	NAS817-6	5340006822115	80205	.CAP, PROTECTIVE	2	EA										

F-15
MAIN LANDING GEAR ASSY
(L.H. H.W.)
PCN 26338A
WCD 36000N

- OUTER CYLINDER WCD 36001N
- PISTON ASSY WCD 36002N
- ORFICE TUBE WCD 36003N
- TORQUE ARM WCD 36004N
- APEX PIN WCD 36006N
- TRUNNION PIN WCD 36007N
- LOWER DRAG BRACE WCD 36008N
- JURY LINK PIN WCD36009N
- LOWER JURY LINK WCD 36010N
- UPPER JURY LINK WCD 36011N
- RETRACT BOLT WCD 36012N
- SPINDLE ASSY WCD 36013N


CRANK
DRAG BOLT
WCD 36014N
COLLAR
ASSY
WCD 36016N
BRACE APEX
PIN
WCD 36019N
SPRING
WCD 36020N
COLLAR
TRUNNION
WCD 36022N
CONNECTING
LINK
WCD 36023N
BELL CRANK
ASSEMBLY
WCD 36025N
HIGH PRESSURE
PISTON
WCD 36026N

FAMILY 1
CONTROL NUMBER LIST

LABO TECH	PLAN TECH	CONTROL NUMBER	JOP DESC	AIRCRAFT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TECHORDER	G019 FLOW DAYS
COOP	POLL	25918A		T-38 MLG	STRUT ASSY	1620-01-014-1984	7531234-20	4S1-75-13	45
DELE		25976A		F-15 MLG	WHEEL INBOARD HALF	1630-01-144-0625	17 OCT 88	4W3-8-23-1	16
DELE		25977A		F-15 MLG	WHEEL OUTBOARD HALF	1630-01-142-7474	01/11/88	4W3-8-23	
DELE		25985A		C-130	WHEEL HALF OUTBOARD	1630-01-155-6299	10 DECEMBER 86	4W3-4-363	
DELE		25986A		C-130	WHEEL HALF INBOARD	1630-01-161-9753	01/11/88	4W3-4-363	
JENS	PRIC	25987A		C-130	WHEEL HALF OUTBOARD	1630-01-030-5437	9542379	4W1-4-393	20
DELE		25988A		C-130	WHEEL HALF INBOARD	1630-01-030-5436	01/11/88	4W1-4-393	
MART	SHEL	25992A		A-10	CARD CIRCUIT GAU-8	1005-01-182-6383	176C2885	11W1-27-7-3	4
MART	SHEL	25993A		B-52	BOOSTER MOTOR	1005-00-604-0260	ABA400ADZ	11F-46-16-4	4
DELE		26012A		F-16 MLG	BRAKE ASSY	1630-01-186-2492	10 OCT 88	4B1-2-1162	30
JENS	RIGB	26029A		C-130	BRAKE PRESSURE PLATE	1630-01-005-4188JT	5002564	4B1-2-1003	16
DELE		26030A		C-130	BRAKE ASSY	1630-00-825-4794JT	10 OCT 88	4B1-2-1003	27
MART	SHEL	26038A		F-4	BOMB RACK MAU-12BB	1095-01-107-9207	64J13210-5	11B29-3-25-2	19
JENS	RIGB	26049A		C-130	BRAKE TORQUE TUBE	1630-00-102-4365	9550151	4B1-2-1003	16
COVI	SHEL	26062A		F-111	INERTIA REEL	1377-00-411-7061	0103157-54	11P9-11-3	8
CRAG	SHEL	26093A		A-10	ELECTRICAL ASSY	5999-00-572-3201AY	201F167	11W1-27-7-3/4	14
COOP	COOP	26108A	-J	F-16 MLG	STRUT ASSY	1620-01-162-7518	2006600-155	4S2-80-3	60
COOP	COOP	26109A		F-16 MLG	DRAG BRACE	1620-01-182-6348	2006000-125	4SA6-32-3	25
COOP	COOP	26110A		F-16 MLG	STEEL PISTON (INNER)	1620-01-200-5320	2006161-103	4S1-100-3	25
COOP	COOP	26111A		F-16 MLG	ALUMINUM PISTON (OUTER)	1620-01-200-7131	2006106-105	4S1-100-3	41
JENS	PRIC	26112A		C-141 MLG	WHEEL HALF INBOARD	1630-01-142-8298	5000295-3	4W1-7-1123	20
JENS	PRIC	26113A		C-141	MLG WHEEL HALF OUTBOARD	1630-01-147-8300	5000296-2	4W1-7-1123	20
MART	SHEL	26146A	-G	T-33	REEL INERTIA	1680-00-138-5515LS	0103178-4A	13A4-17-3	13
MART	SHEL	26176A			M16 RIFLE	1005-00-856-6885	8448600	11W3-5-5-1	9
JENS	PRIC	26177A		F-5 MLG	WHEEL E&F	1630-01-041-6012	5001114-4	4W1-8-63	20
JENS	RIGB	26182A		F-15 MLG	BRAKE TORQUE TUBE C&D	1630-01-068-8013	2606021	4B1-2-1173	16
JENS	PRIC	26183A✓		F-15 MLG	WHEEL A&B	1630-01-137-5742	5000064-10LC	4W1-8-73	5
DELE		26200A		B-52 MLG	WHEEL HALF INBOARD	1630-01-112-3934	17 OCT 88	4W1-7-1193	30
COOP	COOP	26244A		F-15 MLG	LINK ASSY	1620-00-305-1782	68A450758-1001	4S2-73-3	20
DELE		26248A		F-4	ECM POD ADAPTER	1560-00-350-7820BF	27 OCT 87	IF4-1479	
MART	SHEL	26284A		A-37	BOMB SHACKLE RACK	1095-00-055-6035	48A4D2	11B40-2-7-2	10
BENT	POLL	26290A		T-38 MLG	ACT BRACE ASSY	1620-00-105-8933	6-41650-505	4SA6-17-3	30
MART	SHEL	26311A			BATTERY BOX	6140-00-052-3895	66F6230	11W1-31-3-2	5
MART	SHEL	26322A			FAIRING	1005-00-948-8402	11699902	11W1-31-5-2	8
COOP	COOP	26337A✓		F-15 MLG	STRUT ASSY R/H H/W	1620-01-167-0999	68A410501-2012	4A4-22-3	30
COOP	COOP	26338A✓		F-15 MLG	STRUT ASSY L/H H/W	1620-01-167-1000	68A410501-2011	4A4-22-3	30
DELE		26356A		F-16 MLG	STRUT ASSY	1620-01-124-9135	20 FEB 87	4S2-80-3	
MART	SHEL	26357A		M61-A1	ROTOR BODY	1005-00-344-1550	A7790762	11W1-12-4-4-33	61
JENS	RIGB	26363A		E-3A/B/C	HOUSING	1630-01-038-8276	9542025-1	4B1-2-1153	20
MART	SHEL	26404A		MULTIPLE	LAU-100 R/H AIM 9	1440-01-059-6278AB	14-82003-502	11L1-2-11-11	14
MART	SHEL	26405A		B-52	BOX END	1005-00-545-0809	571542-405	11F8-3-7-3	
MART	SHEL	26406A		20MM	M61 FEEDER	1005-00-473-6054	5910555	11W1-7-9-2	11
COOP	TOLM	26409A		F-111 MLG	BELLCRANK	1620-00-199-8482	917617-103	4A4-14-3	20
JENS	RIGB	26410A		F-16 MLG	BRAKE PRESSURE PLT A/B/C	1630-01-186-2484	5007754	4B1-2-1164	16
JENS	RIGB	26411A		F-16 MLG	BRAKE STATIONARY DSK ABC	1630-01-084-4227	5004554	4B1-2-1164	16
JENS	RIGB	26412A		F-16 MLG	BRAKE END PLATE A/B/C/D	1630-01-106-9701	5004557	4B1-2-1164	16
JENS	RIGB	26413A		F-16 MLG	BRAKE ROTATING DISK ABCD	1630-01-106-9702	5004553	4B1-2-1164	16
JENS	RIGB	26461A	-J	F-15 MLG	BRAKE HEAT STACK C/D	1630-01-186-2469	2607431	4B1-2-1173	
JENS	RIGB	26462A	-J	F-15 MLG	BRAKE HEAT STACK A/B	1630-01-146-7682	5000001	4B1-2-1123	
MART	SHEL	26480A		OA037B	LOADER	1005-00-868-3077	66F12270	11W1-7-10-3	10

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
26338A	MNPCB	HR010	N	HB	7	4.70	1.00	4.70
		LF999	N	HB	7	.21	1.00	21
	*							4.91
	MNPGP	00010	N	HB	5	11.60	1.00	11.60
		PP000	N	SS	5	1.16	1.00	1.16
	*							12.76
	MNPGW	PM000	E	DJ	5	.91	1.00	91
		PM002	N	DJ	5	.20	1.00	20
		PM003	N	DJ	5	.01	1.00	1
		WC001	E	KI	5	1.98	1.00	1.98
		WD001	E	HB	5	2.32	1.00	2.32
		WE001	E	DI	5	.96	1.00	96
		WE002	E	DI	5	.96	1.00	96
		WE003	N	DI	5	.63	1.00	63
		WE004	N	DI	5	.37	1.00	37
		WE006	N	DI	5	.16	1.00	16
		WE007	N	DI	5	.17	1.00	17
		WE008	N	DI	5	.21	1.00	21
		WE009	N	DI	5	.26	1.00	26
		WE010	N	DI	5	.17	1.00	17
		WE011	N	DI	5	.25	1.00	25
		WE012	N	DI	5	.16	1.00	16
		WE013	N	DI	5	.16	1.00	16
		WE014	N	DI	5	.16	1.00	16
		WE016	N	DI	5	.25	1.00	25
		WE019	N	DI	5	.16	1.00	16
		WE020	N	DI	5	1.02	2.00	2.04
		WE022	N	DI	5	.17	1.00	17
		WE023	N	DI	5	.17	1.00	17
		WE025	N	DI	5	.17	1.00	17
		WE026	N	DI	5	.46	1.00	46
		XNPGW	X	HB	5	5.56	1.00	5.56
	*							19.02
	MNPNA	NA001	E	DB	2	.41	1.00	41
		NA002	E	DB	2	.61	1.00	61
		NA003	E	DB	2	.33	.61	20
		NA004	E	DB	2	.23	2.00	46
		NA006	E	DB	2	.04	1.00	4
		NA007	E	DB	2	.07	1.00	7
		NA008	E	DB	2	.10	.05	
		NA009	E	DB	2	.02	1.00	2
		NA010	E	DB	2	.07	.96	6
		NA011	E	DB	2	.15	1.00	15
		NA012	E	DB	2	.04	1.00	4
		NA013	E	DB	2	.02	1.00	2
		NA014	E	DB	2	.07	1.00	7
		NA016	E	DB	2	.03	1.00	3

FAMILY I
F-15 MLG

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
26338A	MNPNA	NA019	E	DB	2	.04	1.00	4
		NA020	E	DB	2	.10	2.00	20
		NA022	E	DB	2	.04	1.00	4
		NA026	E	DB	2	.61	1.00	61
		XNPNA	X	DB	2	5.90	1.00	5.90
	*							8.97
	MNPRA	RA001	E	JA	1	6.99	.41	2.86
		RA002	E	JA	1	1.32	1.00	1.32
		RA003	N	JA	1	1.94	.89	1.72
		RA004	E	JA	1	.13	.05	
		RA007	E	JA	1	.04	1.00	4
		RA008	E	JA	1	2.39	.05	11
		RA009	E	JA	1	.04	1.00	4
		RA010	E	JA	1	1.43	.07	10
		RA011	E	JA	1	2.08	.70	1.45
		RA013	E	JA	1	1.11	1.00	1.11
		RA014	E	JA	1	.79	.57	45
		RA016	E	JA	1	2.36	.26	61
		RA020	E	JA	1	.20	.75	15
		RA022	E	JA	1	4.02	.10	40
		RA023	E	JA	1	1.31	1.00	1.31
		RA025	E	JA	1	2.24	1.00	2.24
	*							13.91
	MNPRB	RB001	E	JA	3	3.24	.56	1.81
		RB002	E	JA	3	6.42	.44	2.82
		RB004	E	JA	3	2.59	.05	12
		RB006	N	JA	3	1.41	.05	7
		RB007	E	JA	3	2.36	.11	25
		RB009	E	JA	3	2.25	.05	11
		RB011	E	JA	3	1.01	.05	5
		RB012	N	JA	3	1.41	.10	14
		RB013	E	JA	3	1.81	.05	9
		RB014	E	JA	3	1.13	.05	5
		RB019	E	JA	3	2.28	.10	22
		RB022	N	JA	3	3.62	.10	36
		RB026	E	JA	3	4.16	.33	1.37
	*							7.46
	MNPRC	RC001	N	UP	B	3.05	.74	2.25
		RC002	N	UP	B	12.62	.96	12.11
		RC003	E	UP	B	1.74	.61	1.06
		RC004	E	UP	B	.78	.13	10
		RC006	E	UP	B	.74	.07	5
		RC007	N	UP	B	1.25	.33	41
		RC008	E	UP	B	.62	.26	16
		RC009	E	UP	B	.74	.07	5
		RC010	E	UP	B	.36	.10	3
		RC011	E	UP	B	.81	.81	65

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
26338A	MNPRC	RC012	N	UP	3	2.68	.05	13
		RC013	E	UP	8	.62	.15	9
		RC014	E	UP	6	.77	.48	36
		RC016	E	UP	8	.54	.63	34
		RC019	E	UP	3	.61	.07	4
		RC020	E	UP	8	.92	.82	75
		RC022	E	UP	8	.96	.56	53
		RC026	N	UP	3	5.57	.05	27
		XNPRC	X	UP	8	3.45	1.00	3.45
	*							22.83
	MNPSE	XNPSE	X	SA	2	.50	1.00	50
	*							50
*								[redacted]

36000N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE [redacted] | PAGE [redacted]

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.
	4A4-22-3 4S-1-182	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
F-15 MAIN		26337A
13. SERIAL NUMBER	**14 NOUN**	
	STRUT ASSY	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
68A410501-2010R/H		1620010799928 26337A H / W			
68A410501-2011L/H		1620011671000 [redacted] / W			
68A410501-2012R/H		1620011670999 26337A H / W			
68A410501-2009L/H		1620010572791 26338A H / W			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND INSPECTED (C/P MONE) FOR [illegible]			
		**********"W A R N I N G"**********			
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36000N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

☆ U.S. GOVERNMENT PRINTING OFFICE: 1980—646-168

36000N WORK CONTROL DOCUMENT (MEDS)

1. DATE [redacted] PAGE 2 OF 2 PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	STRUT ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		REQD (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
	001	68A410501-2009 68A410501-2010 68A410501-2011 68A410501-2012			
	REQD	MATCH-UP *********ROUTED COMPONENTS********** NEW SERVICEABLE / REWORKED 958 / NO REWORK		001 MNFGP 002 06 003 MUC1	
		OUTER CYL. 36001N / /			
		PISTON 36002N / /			
		ORIFICE TUBE 36003N / /			
		TORQUE ARM 36004N / /			
		APEX PIN J.L. 36006N / /			
		TRUN. PIN 36007N / /			
		[illegible] 36008N / /			
		JURY LINK PIN [illegible] / /			
		LOWER JURY LINK 36010N / /			
		UP. JURY LINK 36011N / /			
		RETRACT BOLT 36012N / /			
		SPINDLE ASSY 36013N / /			
		SWIVEL CRANK O.B. 36014N / /			
		COLLAR ASSY / /			
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36000N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE 1980—640-168

36000N **WORK CONTROL DOCUMENT (MEDS)** [redacted] PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	STRUT ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		36016N JURY BR. APEX PIN/ / 36019N SPRING / /			
		36020N COLLAR TRUN. / / 36022N CONN. LINK ASSY / /			
		36023N BELL CRANK ASSY / / 36025N HIGH PRESS. PISTON /			
		36026N MISC. (STEEL) / / 36015N MISC. (ALUM) / /			
		36027N MISC. (STAINLESS STEEL) / 36038N			
[redacted]	501 *REQD*	PRE ASSY CLEANING INSPECTION CHECK CAVITIES & INTERIOR FOR FOREIGN MATERIAL PRIOR TO REASSEMBLE *C/P MOVE		001 MNHGP 002 06 003 SA03	
[redacted]	502 *REQD*	[illegible] CLOSE AND/OR ASSEMBLE *C/P MOVE		001 MNHGP 002 06 003 SA03	
[redacted]	504 *REQD*	CHECK TORQUE 2.0' T.O *C/P MOVE		001 MNHGP 002 06 003 SA03	
[redacted]	505 *REQD*	FINGERLOCK CHECK AS PER FIG. 6-2 PAGE 6-6 *C/P MOVE		001 MNHGP 002 06 003 SA03	
[redacted]	506 *REQD*	PRESSURE TEST *C/P MOVE		001 MNHGP 002 06 003 TL07	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36000N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

★ U.S. GOVERNMENT PRINTING OFFICE: 1980—640-365

[redacted] WORK SCHEDULE [redacted]

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE C[redacted]

7. PART NUMBER	8. TECH DATA	9. [redacted]

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	STRUT ASSY

15. DISPATCH STATION	16. PERF RCC/OP [redacted]	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	[redacted]10	MASK, PRIME AND PAINT		001 MNP GP 002 09	
	REQD	*C/P MOVE		003 WB03	
	512	DECALS		001 MNP GP 002 09	
	REQD	*C/P MOVE		003 WB03	
	[redacted]520	FINAL ACCEPTANCE OF WCD PACKAGE FOR COMPLETNESS & ACCURACY OF ALL		001 MNP GP 002 09	
	REQD	PRECEDING OPERATIONS THIS 958 *C/P MOVE		003 WB03	
	[redacted]530	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNP GP 002 09	
	REQD			003 WB03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36000N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

★ U.S. GOVERNMENT PRINTING OFFICE 1980—[redacted]

36001N WORK CONTROL DOCUMENT (MEDS) [redacted] PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.
	4A4-22-3 4S-1-182	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
F 15 MAIN		

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

21337A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
68A410702-1006		RH 1620010753562 26337A R / H	H		
[redacted]		L / H	H /		
		****** UNIT COST: $10,796.46 ******			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		BLAST IAW MIL-STD-1504			
		FMPI IAW MIL-STD-1949 P/O NO1361			
		STRIP IAW MIL-STD-871			
		GRIND IAW MIL-STD-866			
		TEMPER ETCH IAW MIL-STD-867			
		SHOT PEEN IAW MIL-S-13165			
		CAD IAW MIL-STD-370			
		USE IAW MIL-C-8837			
		CHROME PLATE IAW MIL-STD-1501 & P/O NS1891			
		BAKE IAW 4S-1-182 PART 4.1.2			
		IVD ALUM PLATE IAW MIL-C-83488A			
		ALODINE IAW MIL-C-5541			
		HEAT TREAT 290,000/300,000 PSI			
		[redacted]			
		[redacted]			
		[redacted]			
		[redacted]			
		WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH			
		STATIONS.			
		WARNING			
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36001N
		B	D	24B

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

★ U.S. GOVERNMENT PRINTING OFFICE: 1980—640-168

36001N WORK CONTROL DOCUMENT (MEDS)

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO			
		PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQI (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	68A410702-1005 68A410702-1006			
[redacted]		DISASSEMBLE *C/P MOVE		001 MNFGW 002 02 003 LG02 005 [illegible]A5199	
	REQD				
[redacted]		CHEM CLEAN *C/P MOVE		001 MNFGW 002 03 003 SL01	
	REQD				
[redacted]		"LAG" CLEAN ONLY *C/P MOVE		001 MNFGW 002 03 003 SL01	
	REQI				
[redacted]		[illegible]		001 MNFGW 002 03 003 BK03	
	REQD	DATE OUT TIME OUT			
		*C/P MOVE			
[redacted]		*C/P MOVE	M	001 MNFNA 002 05 003 ML04	
	REQD				

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36001N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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★ U.S. GOVERNMENT PRINTING OFFICE: 1980—340-168

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE BOXED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		E & I INSPECTION		001 MNHGW	
	REQD	STRUT CYLINDER (AT TRUNNION COLLAR) O.D. I/B		002 04	
		CYL. 68A410702-1001,-1002 2.6350/2.6400/2.6300		003 EIOI	
		CYL. 68A410702-1003,-1004 2.6950/2.7000/2.6900			
		CYL. 68A410702-1005,-1006 2.7450/2.7600/2.7500			
		UPPER BORE ID 4.9375/4.9405/4.9430			
		LOWER BORE ID 5.2240/5.2260/5.2280			
		OUTBOARD JURY LINK BUSHING I.D. 1.0000/1.0010/1.0040			
		UPPER DRAG BRACE BUSHING I.D. 1.429/1.439/1.441			
		INBOARD JURY LINK BUSIHNG I.D. 1.2500/1.2510/1.254			
		DOOR SPLIT ATTACH BUSHINGS .3125/.3135/.3140			
		SEALING AREA OD 5.6220/5.6240/5.6200			
		TRUNNION PIN BUSHING I.D. 2.0965/2.0975/2.1000			
		OUTBOARD TRUNNION BOSS O.D. 1.5612/1.5600			
		ORIFICE TUBE HOLE 2.746/2.7476/2.749			
		CROSS PIN HOLE .380/.395 (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36001N
		B	D	280

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

★ U.S. GOVERNMENT PRINTING OFFICE: 1980—640-165

WORK CONTROL DOCUMENT (MED)

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FMPI MUST BE PERFORMED.			
		*C/P MOVE			
69	021	REMOVE BUSHINGS THAT STATION 84 CAN NOT REMOVE *C/P MOVE			
26	022	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	023	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	024	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
18	025	HONE LOWER BORE MAX ID 5.228 *C/P MOVE		001 MNPRB 002 01 003 HV02 005 X8745245	
18	026	HONE UPPER BORE MAX ID 4.9430 *C/P MOVE		001 MNPRB 002 01 003 HV02 005 X8745245	
69	040	NICK AND BURR IAW PAGE 5-3 PARAGRAPH 5-8 *C/P MOVE		001 MNPRA 002 03 003 BE01	
62	045	O/S ORIFICE TUBE BUSHING REPAIR IAW DRAWING LE-110 *C/P MOVE*		001 MNPRA 002 03 003 MH04 005 X7831914	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36001N
		B	D	257

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

★ U.S. GOVERNMENT PRINTING OFFICE 1980—640-366

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	050	O/S DRAG BRACE BOSS I.D. 1.6263 REF.#31 FIG. 8-2 *C/P MOVE		001 MNPRA 002 03 003 BEC1	
69	060	O/S TRUNNION SOCKET MAX I.D. 2.2629 REF. #32 FIG. 8-2 *C/P MOVE		001 MNPRA 002 03 003 MHC4 005 X7831914	
69	070	O/S INBOARD JURY BOSS MAX. I.D. 1.4401 REF.#33 FIG 8-2 *C/P MOVE		001 MNPRA 002 03 003 BEC1	
69	080	O/S OUTBOARD TRUNNION BOSS MAX I.D. 1.3241 REF.#34 FIG.8-2 *C/P MOVE		001 MNPRA 002 03 003 BEC1	
69	090	O/S DOOR DRIVE BOSS MAX. I. D. .4391 REF. #35 FIG. 8-2 *C/P MOVE		001 MNPRA 002 03 003 BEC1	
69	095	O/S CROSS PIN HOLE I.D. TO CLEAN UP NOT TO EXCEED .395 MAX.		001 MNPRA 002 03 003 BEC1	
26	098	VAPOR BLASTING *C/P MOVE		001 MNPRC 002 03 003 PBC1	
26	100	STRIP OUTBOARD TRUNNION O.D. ONLY *C/P MOVE		001 MNPRC 002 02 003 SCC2	
26	110	STRIP STEERING COLLAR AREA OD ONLY *C/P MOVE		001 MNPRC 002 02 003 SCC2	
26	113	STRIP CHROME LOWER BORE I.D. *C/P MOVE		001 MNPRC 002 02 003 SCC2	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36001N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-200

[redacted] WORK CONTROL DOCUMENT (MEDS)

1. DATE [redacted]2041	PAGE__OF__PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	115	FIRST GRIND [redacted] ONLY NOT TO EXCEED 5.2440 *C/P MOVE		001 MNPRB 002 02 003 GI05 005 X7831949	
86	120	FIRST GRIND OUTBOARD TENNON BOSS O.D. 1.543 MIN *C/P MOVE		001 MNPRB 002 03 003 GG01 005 X7831950	
86	130	FIRST GRIND COLLAR AREA MIN. O.D. 5.502 *C/P MOVE		001 MNPRB 002 03 003 GG01	
[redacted]		TIME OUT_____DATE OUT_____ *C/P MOVE	M	001 MNPNA 002 06 003 TE03	
		* * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * * * * * * * * * * * * * * * * * * *			
26B	150	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF ETCH TIME OUT_____DATE OUT_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * * * * * * * * * * * * * * * * * * *	M	001 MNPNA 002 06 003 ML04	
26	165	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36001N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1983—403-403

WORK CONTROL DOCUMENT

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. *OPTIONAL

13. SERIAL NUMBER	14. NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26 ✓	170	SHOT PEEN REWORKED AREAS .008/.012 A2 100% COVERAGE *C/P MOVE		001 MNP 002 01 003 SP	RC 02
26 ✓	175	PREPARE COLLAR O.D. FOR CHROME PLATE CLASS III TYPE II MASK/FIXTURE/ETC *C/P MOVE		001 MNP 002 02 003 BE 005 X78	RC 01 31914
26 ✓	178	PREPARE COLLAR O.D. FOR CHROME PLATE GRIT BLAST *C/P MOVE		001 MNP 002 01 003 BL	RC 02
26 ✓	180	CHROME PLATE COLLAR O.D. TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 5.6240/5.622		001 MNP 002 02 003 CP 005 X78	RC 01 31914
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED _____ *C/P MOVE		008 CDC	10
26B ✓	185	BAKE 4 HRS @ 350-400F AFTER CHROME DATE & TIME IN _____ DATE & TIME OUT _____ *C/P MOVE		001 MNP 002 02 003 BK	RC 01
8G ✓	190	FINISH GRIND COLLAR TO 5.6240/5.6240 32 RMS *C/P MOVE		001 MNP 002 03 003 BK	RB 01
26B ✓	191	BAKE 4 HRS @ 350-400F AFTER GRIND DATE & TIME IN _____ DATE & TIME OUT _____ *C/P MOVE		001 MNP 002 02 003 BK	RC 01
26 ✓	192	PREPARE LOWER BORE FOR CHROME PLATE, GRIT BLAST *C/P MOVE		001 MNP 002 01 003 BL	RC 02
26 ✓	194	PREPARE LOWER BORE FOR CHROME PLATE CLASS III TYPE I OR II MASK/FIXTURE/ETC (CONTINUED)		001 MNP 002 02 003 BE 005 X78	RC 01 81949

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36001N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

★ U.S. GOVERNMENT PRINTING OFFICE: 1980—656-100

WORK CONTROL DOCUMENT (MEOS)

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	**14 NOUN**	
	OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		MECHANIC SIGN OFF REQUIRED_____			
26 ✓	195	CHROME PLATE LOWER BORE CLASS III TYPE I OR II SUFFICIENT TO GRIND BACK TO 5.224/5.226		001 MNPRC 002 02 003 CP01 005 X7881949	
		DATE OUT_____TIME OUT_____ MECHANIC SIGN OFF REQUIRED_____ *C/P MOVE		008 CI010	
26B ✓	200	BAKE 4 HRS AT 350-400F AFTER CHROME PLATE DATE IN_____TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
26 ✓	202	PREPARE OUTBOARD TRUNNION BOSS O.D. FOR CHROME PLATE TYPE II CLASS III MASK/FIXTURE/ETC *C/P MOVE		001 MNPRC 002 02 003 BE01 005 X7831914	
		MECHANIC SIGN OFF REQUIRED_____			
24 ✓	204	PREPARE OUTBOARD TRUNNION BOSS FOR CHROME PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL02	
26 ✓	206	CHROME PLATE OUTBOARD TRUNNION BOSS O.D. TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 1.561C/1.560		001 MNPRC 002 02 003 CP01 005 X7831914	
		DATE OUT_____TIME OUT_____ MECHANIC SIGN OFF REQUIRED_____ (CONTINUED)		008 C0020	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36001N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

★ U.S. GOVERNMENT PRINTING OFFICE: 1980—640-165

36001N WORK CONTROL DOCUMENT (MEDS) | 1. DATE 89041 | PAGE 1 OF 4 PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	**14 NOUN**	
	OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
26B	207	BAKE 4 HRS @ 350-400F AFTER CHROME. DATE & TIME IN_____ DATE & TIME OUT_____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
[redacted]	210	FINISH GRIND OUTBOARD TRUNNION BOSS O.D. 1.5612/1.560 32RMS *C/P MOVE		001 MNPRB 002 03 003 GG01 005 X7831950	
[redacted]	215	FINISH GRIND LOWER BORE 5.224/5.226 32 RMS *C/P MOVE		001 MNPRB 002 02 003 GI05 005 X7831949	
26B	225	BAKE 4 HRS AT 350-400F DATE IN_____ TIME IN_____ DATE OUT_____ TIME OUT_____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED*	M	001 MNPNA 002 06 003 ML04	
		HOME, TAKE PRODUCTION COUNT. *			
26	235	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
[redacted]		*C/P MOVE * * * * * * * N O T E * * * * * * * (CONTINUED)	M	001 MNPNA 002 06 003 ZS01	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				36001N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-200

[redacted] CONTROL TOOLING [redacted]

2. JOB ORDER	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 *OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *			
26 ✓	300	PRIOR TO CAD, VAC CAD OR IVD ALUM PLATE, GRIT BLAST ALL AREAS TO BE PLATED *C/P MOVE		001 MNPRC 002 01 003 BLC2	
26 ✓	370	CAD PLATE TYPE II CLASS II 12.5 SQ FT AT 625 - 875 AMPS TIME OUT DATE OUT		001 MNPRC 002 03 003 CAC1	
		*C/P MOVE			
260 ✓	380	BAKE 23 HRS AT 350-400F PRIOR TO FINAL PLATING DATE IN TIME IN		001 MNPRC 002 02 003 BKC1	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
26 ✓	385	CHROMATE CONVERSION FOR TYPE II CAD *C/P MOVE		001 MNPRC 002 02 003 IRC1	
26 ✓	390	VACUUM CAD PLATE OPTIONAL--IF BUSHING HAVE NOT BEEN REMOVED TYPE , CLASS III *C/P MOVE		001 MNPRC 002 02 003 VCC1	
26 ✓	395	HOT WATER RINSE & CLEAN *C/P MOVE*		001 MNPRC 002 02 003 IRC1	
26 ✓	397	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 380 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK (CONTINUED)		001 MNPRC 002 03 003 IVC1	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36001N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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★ U.S. GOVERNMENT PRINTING OFFICE: 1980—840-366

36001N WORK CONTROL DOCUMENT (MEDS) | 1. DATE 89041 | PAGE 1 OF 1 PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		IS DONE, BEFORE USING IVD OPTION. *C/P MOVE			
26	398	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNPRC 002 03 003 TA01	
[redacted]	.65	*C/P MOVE * * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED*	M	001 MNPNA 002 06 003 ML04	
		HERE, TAKE PRODUCTION COUNT. * * * * * * * * * * * * * * * * * * *			
69	405	O/S ORIFICE TUBE BUSHING REPAIR IAW DRAWING LE-110 *C/P MOVE *C/P MOVE		001 MNPRA 002 03 003 BE01	
		P/N LE110-3			
69	409	MACHINE UPPER DRAG BUSH STD *C/P MOVE P/N ST4m13-L2002		001 MNPRA 002 03 003 LE02	
69	410	UPPER DRAG BUSH INSTALLATION STD P/N ST4m13-L2002 (7a) 1.4430/1.4390 SHRINK FIT AT .001/.003 INSIDE FACE TO FACE 1.8284/1.8368 OUTSIDE FACE		001 MNPRA 002 03 003 BE01	
		TO FACE 3.7342/3.7416 MIN 3.7196 FLANGE THICKNESS .0393/.0403 *C/P MOVE			
[redacted]		[redacted] *C/P MOVE P/N7829424-75		001 MNPRA 002 03 003 LE02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36001N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-288

36001N WORK CONTROL DOCUMENT (MEDS)

1. DATE [redacted]

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 *OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	420	O/S UPPER [redacted] ATION P/N 7829424-75 REF #31 FIG 8-2 1.438/1.439 SHRINK FIT AT .001/.003 INSIDE FACE TO FACE 1.8284/1.8368		001 MNHRA 002 03 003 BE01	
		OUTSIDE FACE TO FACE 3.7342/3.7416 MIN 3./196 FLANGE THICKNESS .0393 TO .0403 *C/P MOVE			
[redacted]	429	MACHINE UPPER JURY LINK BUSH STD O/S *C/P MOVE P/NST4M130-16001		001 MNHRA 002 03 003 LE02	
[redacted]	430	UPPER JURY LINK BUSH INSTALLATION OUTBOARD STD P/N ST4M130-16001 1.000/1.001/1.004 FACE TO FACE 6.6294/6.6374/6.656		001 MNHRA 002 03 003 BE01	
		FLANGE THICKNESS .0593/.0603 *C/P MOVE			
[redacted]	439	MACHINE O/S UPPER JURY LINK BUSHING #34 OUTBOARD *C/P MOVE P/N 7829424-77		001 MNHRA 002 03 003 LE02	
[redacted]	440	O/S UPPER JURY LINK BUSH INSTALL. OUTBOARD P/N 7829424-[illegible] REF FIG FIG 8-2 1.000/1.001/1.004 FACE TO FACE 6.294/6.[illegible]/6.656		001 MNHRA 002 03 003 LE01	
		FLANGE THICK. [illegible] .0593/.0603 *C/P MOVE			
[redacted]		[redacted] INBOARD *C/P MOVE P/N ST4M130-20001		001 MNHRA 002 03 003 LE02	
[redacted]		[redacted] ATION INBOARD STD P/N ST4M130-20001 ID 1.250/1.251 FLANGE THICKNESS (CONTINUED)		001 MNHRA 002 03 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36001N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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WORK CONTROL DOCUMENT (MED)

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	**14 NOUN**	
	OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		.0593/.0603 *C/P MOVE			
469	459	MACHINE O/S UPPER AURY LINK BUSH INBOARD #33 *C/P MOVE P/N7829424-81		001 MNPRA 002 03 003 .EC2	
	460	O/S [illegible] INSTALL. INBOARD P/N 7829424-77 REF #33 FIG 8-2 1.250/1.251/1.254 FLANGE THICKNESS .0593/.0603		001 MNPRA 002 03 003 BE01	
		*C/P MOVE			
	469	MACHINE STD DOOR DR[illegible] *C/P MOVE P/N68A410670-2001		001 MNPRA 002 03 003 LE02	
	470	STD DOOR DRIVE BUSH INSTALLATION P/N 68A410670-2001 ID .3125/.3135 FLANGE THICKNESS .027/.030 MIN .019 6 PLACES FACE TO FACE .300/.320/ .284 MIN SHRINK FIT AT .0001/.0021 *C/P MOVE		001 MNPRA 002 03 003 BE01	
	479	MACHINE O/S DOOR DRIVE BOSS BUSH #31 *C/P MOVE P/N7829424-87		001 MNPRA 002 03 003 LE02	
		O/S DOOR DR. BOSS BUSH INSTALLATION P/N 7829424-87 REF #35 FIG 8-2 .3125/.3135/.3160 FLANGE THICKNESS .027/.030 MIN .019 6 PLACES FACE TO FACE .300/.320/.284 MIN SHRINK FIT AT .0001/.0021 *C/P MOVE		001 MNPRA 002 03 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36001N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE 1980—603-003

36001N **WORK CONTROL DOCUMENT (MEDS)** | 1. DATE 89041 | PAGE 14 OF 14 PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	OUTER CYLINDER

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	489	MACHINE STD TRUNNION BUSH *C/P MOVE P/N68A410720-2001		001 MNP RA 002 03 003 LE 2	
69	490	STD TRUNNION BUSH INSTALLATION 68A410720-2001 ID 2.0965/2.0975 SHRINK FIT AT .001/.003 *C/P MOVE		001 MNP RA 002 03 003 BE 1	
69	499	MACHINE O/S TRUNNION SOCKET BUSH #32 *C/P MOVE P/N 7829417-01		001 MNP RA 002 03 003 LE 2	
69	500	O/S TRUNNION SOCKET BUSH INSTALL. P/N 7829417-01 REF #32 Fig 8-2 2.0965/2.0975/2.100 SHRINK FIT AT .001/.003 *C/P MOVE		001 MNP RA 002 03 003 BE 1	
[redacted]	503	MASK, PRIME, AND PAINT *C/P MOVE		001 MN UP 002 09 003 WB 3	
[redacted]	507	DECALS *C/P MOVE		001 MNP UP 002 09 003 WB 3	
[redacted]	510 *REUSE*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL FIELDING ITEMS *C/P MOVE		001 MNP UP 002 09 003 WB 3	
[redacted]	520 *REUSE*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNP UP 002 09 003 WB 3	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36001N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE 1983—383-163

3. QUANTITY	4. PRODUCTION SEC/ROC	5. DATE SCHED	6. DATE COMPLETED
	MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
[redacted]	4A4-22-3 4S-1-182	[redacted]

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
F 15 MAIN		

13. SERIAL NUMBER	14. NOUN
	PISTON ASSY

26378A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		NSN C/N			
[redacted]		/ W			
68A410704-1012R	/H	1620010803407 26337A H / W			
68A410704-1005L	/H	1620010803401 26337A H / W			
68A410704-1006R	/H	1620010818799 26338A H / W			
		******* UNIT COST: $6089.00 *******			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		BLAST IAW MIL-STD-1504			
		FMPI IAW MIL-STD-1949 P/O N01561			
		STRIP IAW MIL-STD-871			
		GRIND IAW MIL-STD-866			
		TEMPER ETCH IAW MIL-STD-867			
		SHOT PEEN IAW MIL-S-13165			
		FPI IAW MIL-STD-6866			
		CAD IAW MIL-STD-970			
		VAC CAD IAW MIL-C-8837			
		CHROME PLATE IAW MIL-STD-1501 P/O N61891			
		BAKE IAW 4S-1-182 MAOI 74-12			
		IVD ALUM PLATE IAW MIL-C-83488A			
		ALODINE IAW MIL-C-5541			
		****** STEEL 300M 280/300 KSI ******			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE			
		FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE			
		APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36002N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980—340-960

[redacted] WORK CONTROL DOCUMENT (MEDS)

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	PISTON ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	68A410704-1005 68A410704-1006 68A410704-1011 68A410704-1012			
[redacted]	*REQD*	DISASSEMBLE *C/P MOVE*		CC1 MNP GW 002 03 003 SL01	
[redacted]	*REQD*	CHEM CLEAN *C/P MOVE		001 MNP GW 002 03 003 SL01	
[redacted]	*REQD*	BLAST CLEAN ONLY *C/P MOVE		001 MNP GW 002 03 003 BL01	
[redacted]	*REQD*	BAKE 4 HRS AT 350-400F DATE IN_____TIME IN_____ DATE OUT_____TIME OUT_____ (CONTINUED)		001 MNP GW 002 03 003 BK03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36002N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—[illegible]

36002N WORK CONTROL DOCUMENT (MEDS) 1 DATE 8904[redacted] [redacted] PAGE

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	PISTON ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
[redacted]	*REQD*	*C/P MOVE	M	001 MNP NA 002 05 003 ML 04	
[redacted]	*REQD*	E & I INSPECTION IAW T.O. 4A4-22-3 TABLE 8-1 PISTON O.D. LOWER AREA		001 MNP GW 002 04 003 EI 01	
		4.495/4.497/4.492 PISTON O.D HEAD AREA 4.385/4.383			
		PISTON ID METERING PIN SEAL AREA 3.7430/3.7450/3.7470 PISTON ID ABOVE METERING PIN SEAL			
		AREA 3.820/3.822 PISTON HEAD AREA ID 4.060			
		LARGE ARM I.D. 2.240/2.242 MAX. TOLERANCE IS 2.100 FOR LIGHT AND HEAVY WEIGHT ONLY.			
		SMALL ARM I.D. 1.240/1.242 MAX. TOLERANCE IS 1.220 HEAVY WEIGHT ONLY PISTON HEAD PIN ID .500/.501			
		FLANGE BUSHING BASE METAL I.D. .625/.626 FLANGE BUSHING ID .501/.502			
		TORQUE ARM BUSHING FACE TO FACE 3.625/3.624 (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36002N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980—330-105

36002N WORK CONTROL DOCUMENT (MEDS)

1. DATE	2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
[redacted]					

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
		-

13. SERIAL NUMBER	14 NOUN
	PISTON ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		TORQUE ARM BUSHING ID 1.118/1.119 TORQUE ARM BUSHING BASE METAL AFTER			
		PLATE 1.219/1.220 INNER AXLE JOURNAL 2.9322/2.9345/2.9296			
		OUTER AXLE JOURNAL 2.9117/2.914/2.9091 BRAKE FLANGE HOLE I.D. .749 MIN. .776 MAX. DIA.			
		NOTE. IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FMPI MUST BE PERFORMED.			
		*C/P MOVE			
26	024	VAPOR DEGREASE *C/P MOVE		001 MNHRC 002 03 003 DG01	
26	016	[illegible] *C/P MOVE		001 MNHRC 002 03 003 [illegible]	
26	028	[illegible] *C/P MOVE		001 MNHRC 002 02 003 LS02	
[redacted]		NICK & BURR *C/P MOVE*		001 MNHRA 002 03 003 BE01	
[redacted]		[redacted] OR HONE [redacted] CLEAN UP AS NECESSARY NOT TO EXCEED 2.300 MAX. DIA. HEAVY WT./LIGHT WT. (CONTINUED)		001 MNHRA 002 03 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36002N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE 1980—640-488

WORK CONTROL DOCUMENT (MEDS)

1. DATE				
2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	PISTON ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		C/P MOVE			
[redacted]	040	POLISH OR HONE SMALL AXLE I.D. TO CLEAN UP AS NECESSARY NOT TO EXCEED 2.070 MAX. DIA. HEAVY WEIGHT ONLY *C/P MOVE*		001 MNPRA 002 03 003 BEC1	
[redacted]	042	O/S TORQUE ARM BOSS MAX ID 1.2835 *C/P MOVE		001 MNPRA 002 03 003 BEC1	
[redacted]	045	O/S UPLOCK BOSS MAX ID .899 *C/P MOVE		001 MNPRA 002 03 003 BEC1	
[redacted]	048	POLISH BRAKE FLANGE HOLES TO REMOVE CORR. NOT TO EXCEED .776 MAX. DIA. *C/P MOVE		001 MNPRA 002 03 003 BEC1	
26 [redacted]	049	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DGC1	
26 [redacted]	050	STRIP CHROME FROM PISTON OD *C/P MOVE		001 MNPRC 002 02 003 SCC2	
26 [redacted]	060	STRIP CHROME FROM PISTON ID *C/P MOVE		001 MNPRC 002 02 003 SCC2	
26 [redacted]	062	STRIP INNER AXLE JOURNAL *C/P MOVE		001 MNPRC 002 02 003 SCC2	
26 [redacted]	065	STRIP OUTER AXLE JOURNAL *C/P MOVE		001 MNPRC 002 02 003 SCC2	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36002N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

[redacted]

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	[redacted]

7. PART NUMBER	8 TECH DATA	[redacted]

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	PISTON ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	070	FIRST GRIND PISTON O.D. MIN OD 4.4750 *C/P MOVE		001 MNFRB 002 03 003 GG01 005 X7831945	
[redacted]	080	FIRST GRIND PISTON ID METERING PIN SEAL AREA MAX ID 3.763 *C/P MOVE		001 MNFRB 002 02 003 SI01 005 X7831945	
[redacted]	082	1ST GRIND INNER AXLE JOURNAL MIN O.D. 2.9250. *C/P MOVE		001 MNFRB 002 03 003 GG01 005 X7831948	
[redacted]	085	1ST GRIND OUTER AXLE JOURNAL MIN O.D. 2.9051 *C/P MOVE		001 MNFRB 002 03 003 GG01 005 X7831948	
[redacted]		TIME OUT_____ DATE OUT_____ * * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *C/P MOVE	M	001 MNFNA 002 06 003 TE03	
26B	100	BAPE 4 HRS WITHIN 8 HRS OF ETCH DATE IN TIME IN		001 MNFRC 002 02 003 BK01	
		DATE OUT_____ TIME OUT_____ *C/P MOVE			
[redacted]		* * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *C/P MOVE	M	001 MNFNA 002 06 003 ML04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36002N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—[illegible]

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	PISTON ASSY

16. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26 ✓	115	VAPOR DEGREASE *C/P MOVE		001 MNHRC 002 03 003 DG01	
26 ✓	120	SHOT PEEN ALL REWORKED AREAS .008/.012 A2 100% COVERAGE *C/P MOVE		001 MNHRC 002 01 003 SP02	
26 ✓	125	PREPARE PISTON I.D. FOR CHROME PLATE, GRIT BLAST. *C/P MOVE		001 MNHRC 002 01 003 BL02	
26 ✓	127	PREPARE FOR CHROME PLATE PISTON I.D. SEAL FIXTURE/MASK/ETC. IAW MIL-STD-1501 & P/O N61891		001 MNHRC 002 02 003 BE01 005 X7831923	
		MECHANIC SIGN OFF REQUIRED_____ *C/P MOVE			
26 ✓	130	CHROME PLATE PISTON I.D. SEAL TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 0.741 TIME OUT DATE OUT		001 MNHRC 002 02 003 CP01 005 X7931923	
		*MECHANIC SIGNOFF REQUIRED_____ *C/P MOVE		000 C1010	
26B ✓	135	BAKE 4 HRS WITHIN 4 HRS OF CHROME PLATE DATE IN _____ TIME IN_____ DATE OUT TIME OUT		001 MNHRC 002 02 003 BK01	
		*C/P MOVE			
26 ✓	136	PREPARE FOR CHROME PLATE PISTON O.D. FIXTURE/MASK/ETC. IAW MIL-STD-1501 & P/O N61891 (CONTINUED)		001 MNHRC 002 02 003 BE01 005 X7831921	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36002N
		B	D	

3. JOB ORDER NO	5. QUANTITY	4 PRODUCTION SEC/RCC	6 DATE [illegible]	[illegible]

7. PART NUMBER	8 TECH DATA	[illegible]

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN	
	PISTON ASSY	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		MECHANIC SIGN OFF REQUIRED_____ *C/P MOVE			
26	139	PREPAPE PISTON O.D. FOR CHROME PLATE, GRIT BLAST. *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	140	CHROME PLATE PISTON O.D. TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 4.497 TIME OUT DATE OUT		001 MNPRC 002 02 003 CP01 005 X7831921	
		*MECHANIC SIGNOFF REQUIRED----------> *C/P MOVE		008 CC010	
26B	150	BAKE 4 HRS WITHIN 4 HRS OF CHROME PLATE DATE IN_____ TIME IN_____ DATE OUT TIME OUT		001 MNPRC 002 02 003 BK01	
		*C/P MOVE			
26	152	PREPARE FOR CHROME PLATE AXLE JOURNALS FIXTURE/MASK/ETC. IAW MIL-STD-1501 & P/C M[illegible]		001 MNPRC 002 02 003 [illegible]01	
		MECHANIC SIGN OFF REQUIRED_____ *C/P MOVE			
26	154	PREPARE AXLE JOURNALS FOR CHROME PLATE, GRIT BLAST. *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	156	CHROME PLATE INNER AXLE JOURNAL TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 2.9345 (CONTINUED)		001 MNPRC 002 02 003 CP01 008 CC020	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SH
DISPATCH	FUNCTIONAL CODE	A	C	36002N
		B	D	

★ U.S. GOVERNMENT PRINTING OFFICE: 1980—[illegible]

36002N **WORK CONTROL DOCUMENT (NEDS)**

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	**14 NOUN**	
	PISTON ASSY	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		TIME OUT_____DATE OUT_____ *MECHANIC SIGNOFF REQUIRED----------> *C/P MOVE			
25	157	CHROME PLATE OUTER AXLE JOURNAL TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 2.9140. TIME OUT DATE OUT		001 MNPRC 002 02 003 CP01 008 C0030	
		*MECHANIC SIGNOFF REQUIRED----------> * P MOVE			
26B	158	BAKE 4 HRS WITHIN 4 HRS OF CHROME PLATE DATE IN_____TIME IN_____ DATE OUT TIME OUT		001 MNPRC 002 02 003 BK01	
		*C/P MOVE			
[redacted]		FINISH GRIND PISTON O.D. 4.4956/4.4975 16RMS *C/P MOVE		001 MNPRB 002 03 003 GG01 005 X7831945	
8	170	FINISH GRIND PISTON ID METERING PIN SEAL AREA 3.743/3.745 32RMS *C/P MOVE		001 MNPRB 002 02 003 GL01 005 X7831945	
8G	175	FINISH GRIND INNER AXLE JOURNAL 2.9022/2.9345 *C/P MOVE		001 MNPRB 002 03 003 GG01 005 X7831948	
[redacted]		FINISH GRIND OUTER AXLE JOURNAL 2.9117/2.9140 *C/P MOVE		001 MNPRB 002 03 003 GG01 005 X7831948	
26B	180	BAKE 4 HRS 350-400F AFTER FINISH GRIND DATE IN_____TIME IN_____ (CONTINUED)		001 MNPRC 002 02 003 BK01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36002N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

2D

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN	
	PISTON ASSY	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]		* * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	
		* *C/P MOVE			
26 ✓	195	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
[redacted]		* * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ZS01	
		* *C/P MOVE			
26 ✓	205	PRIOR TO CAD/VAC CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/ VAC CAD/ IVD PLATED. *C/P MOVE		001 MNPRC 002 01 003 BL02	
26 ✓	210	CAD PLATE TYPE II CLASS 1 2.62 SQ FT AT 141 - 197 AMPS TIME OUT_____DATE OUT_____ *C/P MOVE		001 MNPRC 002 03 003 CA01	
26B ✓	220	BAKE 23 HRS WITHIN 4 HRS OF CAD PLATE DATE IN_____TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36002N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—311-165

[redacted] DOCUMENT (MEDS) | 1. DATE [redacted]

2. JCN NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	PISTON ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	"Q"
26 ✓	225	VACUUM CAD PLATE TYPE I CLASS I OPTIONAL IF BUSHINGS NOT REMOVED NOTE OPERATION 220 MUST BE ACCOMPLISHED PRIOR TO VAC CAD *C/P MOVE		001 MNPRC 002 02 003 VC01	
26 ✓	227	HOT WATER RINSE & CLEAN *C/P MOVE*		001 MNPRC 002 02 003 IR01	
26 ✓	230	CHROMATE CONVERSION FOR TYPE II CAD *C/P MOVE		001 MNPRC 002 02 003 IR01	
26 ✓	233	VAC I.V.D. ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 220 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING I.V.D. OPTION. *C/P MOVE		001 MNPRC 002 03 003 IV01	
26 ✓	234	ALODIN 1200 ALUM PLATE CLASS 1A *C/P MOVE		001 MNPRC 002 03 003 TA01	
[redacted]	.65	[redacted] ONLY IF TANK CAD * * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *C/P MOVE	M	001 MNPNA 002 06 003 ML04	
✓		[redacted] TORQUE [redacted] NG *C/P MOVE P/N 68A410636-2001		001 MNPRA 002 03 003 [redacted]	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENTATION
DISPATCH	FUNCTIONAL CODE	A	C	36002N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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2 U.S. GOVERNMENT PRINTING OFFICE: 1980-0-640

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. TYED SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	PISTON ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	[redacted]	TORQUE ARM BUSH INST[redacted]N P/N SSA410636-2001 ID 1.118/1.119 FIT .001/.0025 FLANGE INBOARD .061/.068/.053		001 MNFRA 002 03 003 BE01	
		FLANGE AXEL SIDE .056/.065/.048 FACE TO FACE OUTSIDE 3.624/3.625/3.608 MIN *C/P MOVE			
[redacted]	244	MACHINE O/S TORQUE ARM BUSHING *C/P MOVE P/N 7829421-01		001 MNFRA 002 03 003 LE02	
[redacted]	245	O/S TORQUE ARM BUSH INSTALLATION P/N 7829421-01 ID 1.118/1.119 INSTALL SAME AS STD *C/P MOVE		001 MNFRA 002 03 003 BE01	
[redacted]	249	MACHINE CAM FOLLOWER BUSHING *C/P MOVE P/N ST4M130-08005		001 MNFRA 002 03 003 LE02	
[redacted]	250	CAM FOLLOWER BUSH INSTALLATION P/N ST4M130-08005 ID .5017.502 FIT .0005/.0015 FLANGE .056/ 061/.048		001 MNFRA 002 03 003 BE01	
		FACE 1.087/1.117/1.071 *C/P MOVE			
[redacted]	254	MACHINE O/S CAM FOLLOWER BUSHING *C/P MOVE P/N 7829424-71		001 MNFRA 002 03 003 LE02	
[redacted]		[redacted] BUSH INSTALLATION P/N 7829424-71 ID .501/.502 INSTALL SAME AS STD *C/P MOVE		001 MNFRA 002 03 003 BE01	
34A	257	MATCH-UP PISTON HEAD (9) AND PISTON (55). IF PISTON HEAD WITH SAME SERIAL # AS PISTON CANNOT BE FOUND (CONTINUED)		001 MNFGP 002 06 003 MH01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENTATION
DISPATCH	FUNCTIONAL CODE	A	C	36002N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1980—311-966

36002N **WORK CONTROL DOCUMENT (MEDS)** [redacted]

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEQ NO	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
	[redacted]	[redacted]

13. SERIAL NUMBER	14. NOUN
	PISTON ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		MISMATCH PISTON HEAD (9) WITH PISTON (55) MIMIMUM OF 30 DEGREES FROM PREVIOUS HOLE IN PISTON HEAD. IF PISTON HEAD (9) PIN HOLES			
		DO NOT MISMATCH HOLES IN PISTON BY A MINIMUM 30 DEGREES REPLACE PISTON HEAD.			
[redacted]	25[redacted]	[redacted] HOLE IN PISTON 55 AS A PILOT *C/P MOVE		001 MNRA 002 03 003 MV[redacted]0	
	260 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNRGP 002 06 003 SA03	
	270 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNRGP 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36002N
		B	D	

AFLC FORM 958 NOV. 80 — PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—[redacted]

4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4A4-22-3 4S-1-182	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
F-15 MLG		
13. SERIAL NUMBER	**14. NOUN**	
	ORIFICE TUBE	263384

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 68A410726-1001		NSN [redacted] C/N 26338A L / H 26337A R / H			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		****** UNIT COST: $1121.67 *********			
		EPI IAW MIL-STD-6866			
		ANODIZE IAW MIL-A-8625 HARD ANODIZE IAW MIL-A-8625 BLAST IAW MIL-STD-1504 ALODINE IAW MIL-C-5541 STRIP IAW MIL-STD-871			
		**********ALUMINUM**********			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY			
		PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLIC-			
		ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY			
		CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS			
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36003N
		B	D	

[redacted] CONTROL DOCUMENT (WEDS) | 1. DATE 89041 | [redacted]

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. [illegible] COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	**14. NOUN**	
	ORIFICE TUBE	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	68A410726-1001			
[redacted]	*REQD*	DISASSEMBLE *C/P MOVE		001 MNP GW 002 02 003 LG 2 005 XB745199	
[redacted]	*REQD*	DEGREASE ONLY *C/P MOVE * * * * * * * * N O T E * * * * * * * * * PROTECT HARD ANODIZE AREA *		001 MNP GW 002 02 003 DG 2	
[redacted]	*REQD*	BLAST CLEAN *C/P MOVE		001 MNP GW 002 03 003 BL 7	
[redacted]	*REQD*	*C/P MOVE	M	001 MNP NA 002 05 003 ZY 5	
[redacted]	*REQD*	E AND I OD 2.995/2.997/2.991 AREA 3 OF FIG 8-7 PAGE 8-19 FROM		001 MNP GW 002 04 003 EI 1	
		BEARING TOWARD ORIFICE TIP FIRST 5 INCHES MIN OD 2.988 8 RMS NO DEFECTS ALLOWED IN SEALING AREA			
		AREA 2 BALANCE OF HARD ANODIZED AREA .030 DEEP DEFECTS 2.935 MIN OD MAX 63 RMS LOCAL REWORK PERMITTED (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36403N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE 1980-340-240

36003N WORK CONTROL DOCUMENT [illegible]

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM [illegible]

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	ORIFICE TUBE

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
[illegible]	025	POLISH HARD ANODIZED AREA AS IF AREA DOES NOT CLEAN UP AS SPEC- IFIED IN T.O., ROUTE TO STRIP *C/P MOVE		001 MNHRA 002 03 003 LEC2	
[illegible]	027	DISASSEMBLE AS REQUIRED BEFORE STRIP ANODIZE. NOTE: REMOVE RIVETS AND STEEL COMPONENTS. *C/P MOVE		001 MNHRA 002 03 003 BEC1	
26 ✓	030	STRIP ANODIZE *C/P MOVE		001 MNHRC 002 03 003 ANC4	
[illegible]		*C/P MOVE * * * * * * * N O T E * * * * * * * IF LAST NOI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNHNA 002 06 003 ZAC2	
		* * * * * * * * * * * * * * * * * * * *			
26 ✓	050	ANODIZE TYPE II CLASS 1 *C/P MOVE		001 MNHRC 002 03 003 ASC3	
69 ✓	055	POLISH TUBE TO 6-8 RMS MAX IN SEALING AREA AS DEFINED IN E & I SECTION 63 RMS MAX REST OF TUBE MIN OD 2.995		001 MNHRA 002 03 003 LEC2	
		*C/P MOVE			
26 ✓	060	HARD ANODIZE TYPE III SUFFICIENT TO BUILD TO MAX OF 2.997 *C/P MOVE		001 MNHRC 002 03 003 AHC1 008 ADC10	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36003N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1983—403-168

36003N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN	
	ORIFICE TUBE	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	070	[redacted]		001 MNFRA	
		8 RMS MAX IN SEALING AREA		002 03	
		63 RMS BALANCE OF HARD ANODIZE AREA		003 LE02	
		MIN AFTER POLISHING 2.994			
		*C/P MOVE			
[redacted]	0	FINAL ACCEPTANCE OF WORK CONTROL		001 MNFGP	
		DOCUMENT FOR COMPLETENESS & ACCURACY		002 06	
	REQD	OF ALL PRECEDING OPERATIONS THIS 958		003 SA03	
[redacted]	100	FINAL PRODUCT VISUAL INSPECTION		001 MNFGP	
		*C/P MOVE		002 06	
	REQD			003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENTATION
DISPATCH	FUNCTIONAL CODE	A	C	36003N
		B	D	

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NAVMC FORM 988 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE 1980—840-988

36004N WORK CONTROL DOCUMENT (MEDS)

1. DATE 89041 | PAGE 1 OF 2 PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4A4-22-3 4S-1-182	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
F 15 MAIN		
13. SERIAL NUMBER	**14. NOUN**	
	TORQUE ARM	36004N

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 68A410646-2005		NSN [redacted] C/N 26336A L / H 26337A R / H 50431A			
		******* UNIT COST: $1542.30 ******* GOVERNING DIRECTIVES: AFLCR 66-31 AFMCI 66-3			
		MAST IAW MIL-STD-1504			
		FMPI IAW MIL-STD-1949 P/O N01561			
		CAD IAW MIL-STD-870 BAKE IAW 4S-1-182			
		CHROME PLATE IAW MAOI 74-12 MIL-STD-1501 & P/C N61891			
		TEMPER ETCH IAW MIL-STD-867			
		STRIP CHROME IAW MIL-STD-871 IVD ALUM PLATE IAW T.O. 1-1A-8 (83438A) ALODINE IAW MIL-C-81541 ******* STEEL [illegible] *******			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY			
		PRACTICES AND HAZARDS ASSOCIATED IN THE BASIC TECHNICAL DATA (T.O.) AND T.O. SUPPLEMENTS REQUIRED FOR [illegible]			
		WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR			
		MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36004N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

★ U.S. GOVERNMENT PRINTING OFFICE: 1980—606-165

[redacted] CONTROL DOCUMENT (MEDS)

1. DATE 89041 | PAGE 2 OF [redacted] PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN	
	TORQUE ARM	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO			
		PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	68A410646-2005			
[redacted]	*REQD*	DISASSEMBLE *C/P MOVE		001 MNR GW 002 02 003 LG02 005 XB745199	
[redacted]	*REQD*	CHEM CLEAN *C/P MOVE		001 MNR GW 002 03 003 SL01	
[redacted]	*REQD*	BLAST CLEAN ONLY *C/P MOVE		001 MNR GW 002 03 003 BL07	
[redacted]	*REQD*	BAKE 4 HRS AT 350-400F DATE IN_____TIME IN_____		001 MNR GW 002 03 003 BK03	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]	*REQD*	*C/P MOVE	M	001 MNR NA 002 05 003 MS03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36004N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—340-160

36004N **WORK CONTROL DOCUMENT (MEDS)** 1. DATE 89041 PAGE 2 OF 2 PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	TORQUE ARM

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		E & I INSPECTION		001 MNPGW 002 04 003 EI01	
	REQD	APEX PIN I.D. .738/.7385/.741			
		TORQUE ARM PIN I. D. 1.118/1.119 1.122 APEX BOSS THICKNESS .998/1.00 T.A. BOSS THICKNESS .933/.943			
		APEX FACE TO FACE ID 1.250/1.252 TORQUE ARM BASE FACE TO FACE 3.626/3.628			
		NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FMPI MUST BE PERFORMED. *C/P MOVE			
69 ✓	025	REMOVE TORQUE ARM PIN *C/P MOVE*		001 MNPRA 002 03 003 BE01	
69 ✓	030	O/S LOCK PIN .225 REQUIRES O/S BOLT *C/P MOVE		001 MNPRA 002 03 003 BE01	
26 ✓	034	VACUUM DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DS01	
26 ✓	036	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26 ✓	038	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
26 ✓	040	STRIP CHROME BASE FACE TO FACE *C/P MOVE		001 MNPRC 002 02 003 BC02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36004N
		B	D	291

AFLC FORM 956 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-165

[redacted] WORK CONTROL DOCUMENT (MEDS)

1. DATE 89041 | PAGE 1 OF 1 PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL/DESIGN/SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	TORQUE ARM

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	050	STRIP CHROME BASE BOSS I.D. *C/P MOVE		001 MNHRA 002 01 003 BE01	
[redacted]	060	STRIP CHROME APEX FACE TO FACE *C/P MOVE		001 MNHRC 002 02 003 SC02	
26	070	STRIP CHROME APEX BOSS I.D. *C/P MOVE		001 MNHRC 002 02 003 SC02	
[redacted]	080	FIRST GRIND BASE LUG FACES TO CLEAN UP NOT TO EXCEED 3.646 *C/P MOVE		001 MNHRB 002 01 003 GJ01	
[redacted]	090	FIRST GRIND APEX LUG FACES NOT TO EXCEED .982 NOTE: APEX LUGS FACE TO FACE NOT TO EXCEED 1.2750 *C/P MOVE		001 MNHRB 002 01 003 GJ01	
[redacted]	100	FIRST GRIND BASE BOSS I.D. NOT TO EXCEED 1.138 *C/P MOVE		001 MNHRB 002 01 003 GJ01 005 X857942	
8	110	FIRST GRIND APEX LUG BOSS I.D. NOT TO EXCEED .758 *C/P MOVE		001 MNHRB 002 01 003 GJ01 005 X857942	
[redacted]		DATE OUT_____TIME OUT_____ *C/P MOVE	M	001 MNHNA 002 06 003 TE03	
		* * * * * * * *N O T E* * * * * * * * * IF LAST NDI OPERATION IS COMPLETED * HERE, TAKE PRODUCTION COUNT. *			
26B	130	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF ETCH. DATE IN _____TIME IN _____ (CONTINUED)		001 MNHRC 002 02 003 BK01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36004N
[redacted]		B	D	

AMC FORM 554 NOV 80 — PREVIOUS EDITION WILL BE USED

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[redacted] WORK CONTROL DOCUMENT (MEDS)

1. DATE	PROG [redacted]

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN	
	TORSLE ARM	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED * HERE, TAKE PRODUCTION COUNT. *	M	001 MNPNA 002 06 003 ML04	
		* * * * * * * * * * * * * * * * * * * *			
26 [redacted] ✓	145	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26 [redacted] ✓	150	PREPARE BASE/APEX LUGS FOR CHROME PLATE, GRIT BLAST *C/P MOVE		001 MNPRC 002 01 003 BL04	
26 [redacted] ✓	155	PREPARE FOR CHROME PLATE OF BASE/ APEX LUGS, FIXTURE/ MASK/ETC IAW MIL-STD-1501 & P/O N61891 *MECHANIC SIGNOFF REQUIRED---------->		001 MNPRC 002 02 003 BE01 005 X7929107	
26 [redacted] ✓	160	GRIND PLATE BASE LUGS FACE TO FACE TYPE II CLASS II SUFFICIENT TO GRIND BACK TO 3.626/3.628 TIME OUT DATE OUT		001 MNPRC 002 02 003 CP01 005 X7929107	
		*MECHANIC SIGNOFF REQUIRED----------> *C/P MOVE		008 CD010	
26 [redacted] ✓	170	CHROME PLATE APEX LUGS FACE TO FACE TYPE II CLASS II SUFFICIENT TO GRIND BACK TO 1.250/1.252 TIME OUT_____DATE OUT_____		001 MNPRC 002 02 003 CP01 005 X7929107	
		*MECHANIC SIGNOFF REQUIRED----------> *C/P MOVE		008 CD020	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36004N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1988-550-880/80015

36004N **WORK CONTROL DOCUMENT (MEDS)** 1 DATE [redacted] PAGE 1 OF 2 PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	TORSUE ARM

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26 ✓	170	BAKE 4 HRS AT 350 TO 400F WITHIN 4 HRS OF CHROME TIME IN DATE IN		001 MNPRC 002 02 003 BK01	
		TIME OUT_____DATE OUT_____ *C/P MOVE			
26 ✓	175	PREPARE BASE/APEX BOSS FOR CHRUME PLATE. GRIT BAST *C/P MOVE		001 MNPRC 002 01 003 BL04	
26 ✓	177	PREPARE FOR CHROME PLATE OF BASE/ APEX BOSS ID, FIXTURE/MASK/ETC IAW MIL-STD-1501 & P/O N6:991 *MECHANIC SIGNOFF REQUIRED--------> *C/P MOVE		001 MNPRC 002 02 003 BE01	
26 ✓	180	CHROME PLATE BASE BOSS I.D. TYPE II CLASS II SUFFICIENT TO GRIND BACK TO 1.118/1.119 TIME OUT_____ DATE OUT_____ *MECHANIC SIGNOFF REQUIRED-------> *C/P MOVE		001 MNPRC 002 02 003 CP01 008 CI010	
26 ✓	190	CHROME PLATE APEX BOSS I.D. TYPE II CLASS II SUFFICIENT TO GRIND BACK TO .7380/.7385 TIME OUT DATE OUT *MECHANIC SIGNOFF REQUIRED--------> *C/P MOVE		001 MNPRC 002 02 003 CP01 008 CI020	
26B ✓	200	BAKE 4 HRS AT 350 TO 400F WITHIN 4 HRS OF CHROME DATE IN_____TIME IN_____ (CONTINUED)		001 MNPRC 002 02 003 BK01	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				36004N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

★ U.S. GOVERNMENT PRINTING OFFICE: 1980—640-100

36004N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89041 | PAGE 7 OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	**14 NOUN**	
	TORQUE ARM	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DATE OUT_____ TIME OUT_____ *C/P MOVE			
18 ✓	210	FINISH GRIND BASE LUG FACE TO FACE TO 3.626/3.618 *C/P MOVE		001 MNPRB 002 01 003 GJ01	
18 ✓	220	FINISH GRIND APEX FACE TO FACE TO 1.000/1.002/.998 - FACE TO FACE BETWEEN LUGS 1.252/1.250 *C/P MOVE		001 MNPRB 002 01 003 GJ01	
18 ✓	230	FINISH GRIND BASE BOSS I.D. 1.118/1.117 *C/P MOVE		001 MNPRB 002 01 003 GJ01 005 X8579#2	
18 ✓	240	FINISH GRIND APEX BOSS I.D. .7380/.7385 *C/P MOVE		001 MNPRB 002 01 003 GJ01 005 X8579#2	
26B ✓	250	BAKE 4 HRS @ 350-400 TIME IN_____ DATE IN_____ TIME OUT_____ DATE OUT_____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
[redacted]		*C/P MOVE * * * * * * *N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED HERE, TAKE SPECIAL DR COUNT.	M	001 MNPNA 002 06 003 ML04	
		* * * * * * * * * * * * * * * * * * * *			
26 ✓	265	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
[redacted]		*C/P MOVE * * * * * * *N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED * (CONTINUED)	M	001 MNPNA 002 06 003 ZS01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36004N
		B	D	285

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

★ U.S. GOVERNMENT PRINTING OFFICE 1980—640-166

[redacted] WORK CONTROL DOCUMENT (MEDS) | 1 DATE [redacted] | PAGE [redacted] OF [redacted] PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN	
	TORQUE ARM	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		HERE, TAKE PRODUCTION COUNT. *			
26 ✓ [redacted]	275	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED		001 MNHRC 002 01 003 BL02	
26 ✓ [redacted]	280	CAD PLATE TYPE II CLASS II .25 SQ FT AT 12.5 - 17.5 AMPS TIME OUT OF TANK_____ *C/P MOVE		001 MNHRC 002 03 003 CA01	
260 ✓ [redacted]	290	BAKE 23 HRS WITHIN 4 HRS OF CAD PLATE DATE IN TIME IN		001 MNHRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
26 ✓ [redacted]	300	CHROMATE CONVERSION FOR TYPE II CAD *C/P MOVE		001 MNHRC 002 02 003 IR01	
[redacted]	[redacted]	*C/P MOVE * * * * * * * *N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED *	M	001 MNHNA 002 06 003 ML04	
		HERE, TAKE PRODUCTION COUNT. *			
26 ✓ [redacted]	313	VAC IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 290 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE		001 MNHRC 002 03 003 IV01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36004N
		B	D	

AFLC FORM 958 NOV. 80 — PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-160

36004N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041 | PAGE 2 OF 9 PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN	
	TORQUE ARM	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26 ✓	317	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNT RC 002 03 003 TA01	
	316	PAINT,FINAL,DECAL *C/P MOVE		001 MNP GP 002 09 003 WB03	
	320 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNP GP 002 09 003 WB03	
	330 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNP GP 002 09 003 WB03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36004N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1983—403-103

36006N WORK CONTROL DOCUMENT (MEDS) [redacted] 89041 PAGE

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	APEX PIN - JURY LINK

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	68A410764-2001			
	*REQD)	DISASSEMBLE *C/P MOVE		001 MNPGW 002 02 003 LG02	
	REQD	DEGREASE ONLY *C/P MOVE		005 X8745199 001 MNPGW 002 02 003 DG02	
	REQD	BLAST CLEAN ONLY *C/P MOVE		001 MNPGW 002 03 003 BL07	
	REQD	BAKE 4 HRS AT 350-400F DATE IN_____TIME IN_____		001 MNPGW 002 03 003 BK03	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
	REQD	*C/P MOVE	M	001 MNPNA 002 05 003 MS03	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				36006N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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WORK CONTROL DOCUMENT (MEDS)

36006N

1 DATE 89041 | PAGE 8 OF __ PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	APEX PIN - JURY LINK

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		E AND I INSPECT		001 MNFGW 002 04 003 EI01	
	REQD	PIN OD .6860/.6870/.6840			
26 ✓	025	*C/P MOVE VAPOR DEGREASE *C/P MOVE		001 MNFRC 002 03 003 DG01	
26 ✓	030	STRIP CAD *C/P MOVE		001 MNFRC 002 02 003 CS01	
26 ✓	035	STRIP RUST *C/P MOVE		001 MNFRC 002 02 003 CS02	
26 ✓	040	STRIP CHROME FROM PIN *C/P MOVE		001 MNFRC 002 02 003 SC02	
8 ✓	[redacted]	FINISH GRIND PIN OD [redacted] .6860 *C/P MOVE		001 MNFRB 002 01 003 GE00	
[redacted]		*C/P MOVE TIME OUT_____DATE OUT_____	M	001 MNFNA 002 06 003 TE03	
		* * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *			
26B ✓	070	BAKE 4 HRS WITHIN 4 HRS OF ETCH DATE IN_____TIME IN_____		001 MNFRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36006N
		B	D	290

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

★ U.S. GOVERNMENT PRINTING OFFICE: 1985—461-016

36006N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE [redacted]89041 | PAGE 4 OF ___ PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	APEX PIN - JURY LINK

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		*C/P MOVE * * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNFNA 002 06 003 ML04	
26 ✓ [redacted]	085	VAPOR DEGREASE *C/P MOVE		001 MNFRC 002 03 003 DG01	
26 ✓ [redacted]	090	SHOT PEEN PIN OD .008/.012 A2 100% COVERAGE *C/P MOVE		001 MNFRC 002 01 003 SP02	
26 ✓ [redacted]	093	PREPARE FOR CHROME PLATE OF PIN O.D. FIXTURE/MASK/ETC IAW MIL-STD-1501		001 MNFRC 002 02 003 BE01	
		*MECHANIC SIGNOFF REQUIRED---------> *C/P MOVE			
26 ✓ [redacted]	097	PREPARE PIN O.D. FOR CHROME PLATE GRIT BLAST *C/P MOVE		001 MNFRC 002 01 003 BL04	
26 ✓ [redacted]	100	CHROME PLATE PIN O.D. TYPE II CLASS III SUFFICIENT TO GRIND BACK TO .687.		001 MNFRC 002 02 003 CP01	
		TIME OUT_____DATE OUT_____ *MECHANIC SIGNOFF REQUIRED--------> *C/P MOVE		008 CQ010	
26B ✓ [redacted]	110	BAKE 4 HRS WITHIN IN 4 HRS OF CHROME DATE IN_____TIME IN_____		001 MNFRC 002 02 003 BK01	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36006N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

★ U.S. GOVERNMENT PRINTING OFFICE: 1980—640-165

WORK CONTROL DOCUMENT (MEDS)

36006N

1. DATE 89041 | PAGE [redacted] OF [redacted] PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN	
	APEX PIN - JURY LINK	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DATE OUT_____TIME OUT_____			
8 ✓	120	*C/P MOVE FINISH GRIND PIN OD .6860/.6870 *C/P MOVE		001 MNFRB 002 01 003 GE00	
26B [redacted] ✓	130	BAKE 4 HRS AT 350-400F DATE IN_____TIME IN_____		001 MNFRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *	M	001 MNFNA 002 06 003 ML04	
26 [redacted] ✓	145	VAPOR DEGREASE *C/P MOVE		001 MNFRC 002 03 003 DG01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNFNA 002 06 003 ZS01	
26 [redacted] ✓	155	PRIOR TO CAD/IVD, GRIT BLAST ALL AREASE TO BE CAD/IVD PLATED *C/P MOVE		001 MNFRC 002 01 003 BL04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36003N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—340-165

36006N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89041 | PAGE 6 OF ___ PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	APEX PIN - JURY LINK

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26 ✓	160	CAD PLATE TYPE II CLASS II .03 SQ FT AT 1.5 - 2.1 AMPS *C/P MOVE		001 MNFRC 002 03 003 CA01	
26B ✓	170	TIME OUT_____DATE OUT_____ BAKE 23 HRS WITHIN 4 HRS OF CAD 3.4 SQ FT AT 170-238 AMPS DATE IN_____TIME IN_____		001 MNFRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
26 ✓	175	CHROMATE CONVERSION FOR TYPE II CAD *C/P MOVE		001 MNFRC 002 02 003 IR01	
.65	*REQD*	* * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNFNA 002 06 003 ML04	
26 ✓	185	VAC. I.V.D. ALUM. PLATE CLASS 2 TYPE II NOTE:OPERATION--170 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING I.V.D. OPTION *C/P MOVE		001 MNFRC 002 03 003 IV01	
26 ✓	190	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNFRC 002 03 003 TA01	
	200 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNFGP 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36006N
		B	D	293

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

[redacted] WORK CONTROL DOCUMENT (HELD) [redacted] 89041 [redacted]

36006N

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN	
	APEX PIN - JURY LINK	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	210 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNFGP 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36006N
		B	D	294

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-016

36007N WORK CONTROL DOCUMENT (MEDS) | 1 DATE 89041 | PAGE ___ OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.
	4A4-22-3 4S-1-182	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 *OPTIONAL
F 15 MAIN		

13. SERIAL NUMBER	14 NOUN
	TRUNNION PIN

26338A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 68A410735-2001		NSN [redacted] C/N 26338A L / H 26337A R / H			
		******* UNIT COST: $344.76 ******* GOVERNING DIRECTIVES: AFLCR 66-31 MANDI 6[illegible]-2 BLAST IAW MIL-STD-[illegible]			
		FMPI IAW MIL-STD-1949 P/O N01561 STRIP IAW MIL-STD-871 GRIND IAW MIL-STD-84[illegible]			
		TEMPER ETCH IAW MIL-STD-867 SHOT PEEN IAW MIL-S-13165 STEEL ABOVE 240,000 PSI			
		CAD IAW MIL-STD-870			
		CHROME PLATE IAW MIL-STD-1501 P/O N61891 BAKE IAW 4S-1-182 MAINT 74-12			
		IVD ALUM PLATE IAW MIL-C-83488A ALODINE IAW MIL-C-5541 HEAT TREAT 280,000/300,000 PSI ******** STEEL 30CP ********			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAS BEEN THOROUGHLY [illegible] AND APPLIED [illegible]			
		PRACTICES AND PROCEDURES CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS			
		WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR			
		MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. WARNING (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36007N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-[illegible]

36007N WORK CONTROL DOCUMENT (MEDS) [redacted] PAGE __ OF __ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN	
	TRUNNION PIN	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	C01	68A410735-2001			
[redacted]	*REQD*	DISASSEMBLE *C/P MOVE		001 MNHGW 002 02 003 LEC2 005 X8745199	
[redacted]	*REQD*	DEGREASE ONLY *C/P MOVE		001 MNHGW 002 02 003 DG02	
[redacted]	*REQD*	BLAST CLEAN ONLY *C/P MOVE		001 MNHGW 002 03 003 BL07	
[redacted]	*REQD*	BAKE 4 HRS AT 1200-1400F DATE IN _____ TIME IN _____		001 MNHGW 002 03 003 BK03	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
[redacted]	*REQD*	*C/P MOVE	M	001 MNHNA 002 05 003 MS03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36007N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE 1980—640-168

36007N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89041 | 3 PAGE__OF__PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	**14 NOUN**	
	TRUNNION PIN	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		E & I INSPECTION		001 MNRGN 002 04 003 EI01	
	REQD	LARGE O.D. 2.0940/2.0955/2.0900 MIN			
		SMALL O.D. 1.4978/1.4988 /1.4950 MIN			
		CROSS PIN HOLE .380/.385 /.395 MAX.			
		NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FMPI MUST BE PERFORMED. *C/P MOVE			
69 ✓	030	POLISH CROSS PIN HOLE .395 MAX *C/P MOVE		001 MNRRA 002 03 003 BE01	
26 ✓	034	VAPOR DEGREASE *C/P MOVE		001 MNRRC 002 03 003 DG01	
26 ✓	036	STRIP CAD *C/P MOVE		001 MNRRC 002 02 003 CS01	
26 ✓	038	STRIP RUST *C/P MOVE		001 MNRRC 002 02 003 [illegible]	
26 ✓	040	STRIP CHROME FROM LARGE OD *C/P MOVE		001 MNRRC 002 02 003 SC02	
26 ✓	050	STRIP CHROME FROM SMALL OD *C/P MOVE		001 MNRRC 002 02 003 SC02	
[redacted] ✓		[redacted] 0770 *C/P MOVE		001 MNRRB 002 02 003 GE02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36007N
		B	D	292

AFLC FORM 558 NOV. 80 PREVIOUS EDITION WILL BE USED

★ U.S. GOVERNMENT PRINTING OFFICE: 1988—548-128

36007N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89041 | PAGE 4 OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	TRUNNION PIN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	070	FIRST GRIND SM[redacted]80 *C/P MOVE		001 MNHRB 002 02 003 GE02	
[redacted]		TIME OUT_____DATE OUT_____ *C/P MOVE	M	001 MNHNA 002 06 003 TE03	
		* * * * * * * N O T E * * * * * * * IF LAST NDI OPERAITON IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * * * * * * * * * * * * * * * * * *			
26B [redacted] ✓	090	BAKE 4 HRS WITHIN 8 HRS OF ETCH DATE IN_____TIME IN_____		001 MNHRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * N O T E * * * * * * * IF LAST NDI OPERAITON IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *	M	001 MNHNA 002 06 003 ML04	
26 [redacted] ✓	105	VAPOR DEGREASE *C/P MOVE		001 MNHRC 002 03 003 DG01	
26 [redacted] ✓	110	SHOT PEEN REWORKED AREAS .008/.012 A2 100% COVERAGE *C/P MOVE		001 MNHRC 002 01 003 SP02	
26 [redacted] ✓	113	PREPARE O.D. FOR CHROME PLATE TYPE II CLASS III MASK/FIXTURE/ETC (CONTINUED)		001 MNHRC 002 02 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36007N
		B	D	29B

AFLC FORM 958 NOV. 80 — PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980-340-165

36007N **WORK CONTROL DOCUMENT (MEDS)** 1 DATE 89041 PAGE 5 OF PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN	
	TRUNNION PIN	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		MECHANIC SIGN OFF REQUIRED_____ *C/P MOVE			
26 ✓ [redacted]	117	PREPARE O.D. FOR CHROME PLATE, GRIT BLAST *C/P MOVE		001 MNHRC 002 01 003 BL04	
26 [redacted] ✓	120	CHROME PLATE LARGE O.D. TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 2.0955		001 MNHRC 002 02 003 CP01 008 CO010	
		DATE OUT_____TIME OUT_____ MECHANIC SIGN OFF REQUIRED_____ *C/P MOVE			
24 - ✓ [redacted]	130	CHROME PLATE SMALL O.D. TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 1.4988		001 MNHRC 002 02 003 CP01 008 CO020	
		DATE OUT_____TIME OUT_____ MECHANIC SIGN OFF REQUIRED_____ *C/P MOVE			
26B [redacted] ✓	135	BAKE 4 HRS AT 350 TO 400F WITHIN 4 HRS OF CHROME PLATE DATE IN TIME IN		001 MNHRC 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
8 [redacted]	150	FINISH GRIND LARGE [redacted] 2.0940/2.0955 OD *C/P MOVE		001 MNHRB 002 02 003 GE02	
8 [redacted] ✓	160	FINISH GRIND SMALL OD [redacted] 1.4978/1.4988 O.D.		001 MNHRB 002 02 003 GE02	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36007N
		B	D	299

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-168

36007N **WORK CONTROL DOCUMENT (MEDS)** | 1. DATE 89041 | PAGE __ OF __ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	TRUNNION PIN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		C/P MOVE			
26B ✓	170	BAKE 4 HRS AT 350-400F DATE IN_____ TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____ TIME OUT_____ *CP MOVE			
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED*	M	001 MNPNA 002 06 003 ML04	
		HERE, TAKE PRODUCTION COUNT. *			
26 ✓	185	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
[redacted]		PRODUCTION COUNT AND/O *C/P MOVE * * * * * * * * N O T E * * * * * * * * *	M	001 MNPNA 002 06 003 ZS01	
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *			
26 ✓	191	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MNPRC 002 01 003 BL04	
26 ✓	192	CAD PLATE TYPE II CLASS II .115 SQ FT AT 5.75 - 8. AMPS *C/P MOVE		001 MNPRC 002 03 003 CA01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36007N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

300

★ U.S. GOVERNMENT PRINTING OFFICE: 1980—0-311-822

36007N **WORK CONTROL DOCUMENT (MEDS)**

1 DATE 89041 | PAGE 7 OF 7 PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 *OPTIONAL

13. SERIAL NUMBER	14 NOUN
	TRUNNION PIN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26D ✓	196	BAKE 23 HRS WITHIN 4 HRS OF CAD PLATE DATE IN_____ TIME IN_____		001 MNPRC 002 02 003 BK01	
		DATE OUT_____ TIME OUT_____ *C/P MOVE			
26 ✓	197	CHROMATE CONVERSION FOR TYPE II CAD *C/P MOVE		001 MNPRC 002 02 003 IR01	
[redacted]	.65	*C/P MOVE * * * * * * * * N O T E * * * * * * * * * IF LAST NOT OPERATION IS COMPLETED*	M	001 MNPNA 002 06 003 ML04	
		HERE, TAKE PRODUCTION COUNT. *			
26 ✓	201	VAL IVD ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION 196 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION. *C/P MOVE		001 MNPRC 002 03 003 IV01	
26 ✓	203	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNPRC 002 03 003 TA01	
	205 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETNESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPGP 002 06 003 SA03	
	210 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNPGP 002 06 003 SA03	

21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH STA. FUNCTIONAL CODE	A	C	
	B		

36008N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89041 | PAGE 1 OF PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.
	4A4-22-3 4S-1-182	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
F 15 MAIN		

13. SERIAL NUMBER	14 NOUN
	LOWER DRAG BRACE

26738A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 68A410792-1001		NSN 1620003654004 C/N 26338A L / H 26337A R / H			
		******* UNIT COST: $1710.59 ******* GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 PLANT IAW MIL-STD-1504 FNP1 IAW MIL-STD-1949 P/O NO1561 RIVET IAW 1F-15A-3 CAD IAW MIL-S-10-370			
		VAC CAD IAW MIL-C-8837 BAKE IAW 4S-1-182 IAW MAOI 74-12 ALODINE IAW MIL-C-5541			
		IVD ALUM PLATE IAW MIL-C-83488A HEAT TREAT 280,000/300,000 PSI ******* [illegible] 30CM *******			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY			
		PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE [illegible]			
		WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR			
		MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. WARNING			
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36008N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1985—461-165

3600BN WORK CONTROL DOCUMENT (MEDS)

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	LOWER DRAG BRACE

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	68A410792-1001			
[redacted]	*REQD*	DISASSEMBLE *C/P MOVE		001 MNFGW 002 02 003 LG02 005 x2745199	
[redacted]	*REQD*	CHEM CLEAN *C/P MOVE		001 MNFGW 002 03 003 SL01	
[redacted]	*REQD*	LAST CLEAN ONLY *C/P MOVE		001 MNFGW 002 03 003 BL01	
[redacted]	*REQI*	SOAK 4 HRS 100% COMPLIANCE REQUIRED DATE IN_____ TIME IN_____		001 MNFGW 002 03 003 BK03	
		DATE OUT_____ TIME OUT_____ *C/P MOVE			
[redacted]	*REQD*	*C/P MOVE	M	001 MNFNA 002 05 003 MS03	
[redacted]	*REQD*	E AND I INSPECT BUSHING (7) ID 1.4380/1.439 WEAR 1.441 (CONTINUED)		001 MNFGW 002 04 003 EI01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	3600BN
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980-0-688-032/6

3600BN WORK CONTROL DOCUMENT

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	LOWER DRAG BRACE

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		BASE METAL 1.500/1.5015 AFTER PLATE FLANGE .0393/.0403/.032 BUSHING (6) ID 1.373/1.376/1.378 BASE METAL 1.531/1.5325 AFTER PLATE			
		FLANGE .039/.040/.032 BUSHING (8) ID 1.4380/1.439/1.441 BUSHING BASE METAL 1.562/1.5625 AFTER PLATE			
		BUSHING 6&7 INSIDE FACE .9577/.9497/ .9354 OUTSIDE DEMEINSION OVERALL OF BUSHING 6&7 3.2580/3.2708/3.2464			
		6&7 3.2580/3.2464 WITH BUSHING NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FMPI			
		MUST BE PERFORMED. *C/P MOVE			
26	030	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DGO1	
26	035	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CSO1	
26	037	STRIP ROD1 *C/P MOVE		001 MNPRC 002 02 003 CSO2	
[redacted]	040	LOCK SLEEVE REPLACE IF CRACK[redacted]R EXCESSIVE WEAR FROM CONTACT STRUT CYL. SLOT EXSIST DRILL OUT RIVET USING 5/32 DRILL DO		001 MNPRA 002 03 003 BE01	
		NOT DRILL INTO BASE METAL ARBER PRESS DRAG BRACE FINGER OUT OF LOCK SLEEVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	3600BN
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE 1980—640-165

36008N **WORK CONTROL DOCUMENT (MEDS)** 1. DATE 890427 PAGE 1 OF 1 PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN	
	LOWER DRAG BRACE	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
169	[illegible]	[illegible] .51 MAX INDEX 53 FIG 1-3 *C/P MOVE		001 MNFRA 002 03 003 MVC1	
69	04	O/S DIAMETER .5961 MAX INDEX 55 FIG 1-3 *C/P MOVE		001 MNFRA 002 03 003 MVC1	
69	046	O/S CYL ATTACH BOSS 1.6271 MAX 7829424 INDEX 57 FIG 1-3 *C/P MOVE		001 MNFRA 002 03 003 MVC1	
26	050	VPAOR DEGREASE *C/P MOVE		001 MNFRC 002 03 003 DGC1	
26	05.	PRIOR TO CAD/TVD, GRIT BLAST ALL AREAS TO BE CAD/TVD PLATED. *C/P MOVE		001 MNFRC 002 01 003 BLC2	
26	060	CAD PLATE TYPE II CLASS II 11.26 oz FT AT 560 - 795.2 AMPS TIME OUT DATE OUT		001 MNFRC 002 03 003 CAC1	
		*C/P MOVE			
26B	070	BAKE 25 MAX [illegible] AFTER A MAX OF CAD DATE IN ----------TIME IN----------		001 MNFRC 002 02 003 BKC1	
		DATE OUT ----------TIME OUT---------- *C/P MOVE			
26	080	CHROMATE CONVERSION FOR TYPE II CAD *C/P MOVE		001 MNFRC 002 02 003 IRC1	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36008N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—840-160

[redacted] 36008N WORK CONTROL DOCUMENT (MED) [redacted] PAGE__OF__PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEQNCE	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	LOWER DRAG BRACE

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26 ✓	090	VAC CAD PLATE IF BUSHING OR SLEEVE HAVE NOT BEEN REMOVED *C/P MOVE		001 MNPRC 002 02 003 VC01	
26 ✓	092	HOT WATER RINSE AFTER VAC CAD *C/P MOVE		001 MNPRC 002 02 003 IR01	
26 ✓	094	VAC. I.V.D. ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION --070 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING I.V.D. OPTION *C/P MOVE		001 MNPRC 002 03 003 IV01	
26 ✓	096	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNPRC 002 03 003 TA01	
[redacted] 1	.65	*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	
		* * * * * * * * * * * * * * * * * * * *			
69 ✓	100	MACHINE NEW LOCK SLEEVE *C/P MOVE P/N 68A410689-2001		001 MNPRA 002 03 003 MV01	
69 ✓	101	INSTALL NEW LOCK [redacted] 68A410 689-2001 USING HEAT SHRINK METHOD *C/P MOVE		001 MNPRA 002 03 003 BE01	
69 ✓	102	INSTALL [redacted] T/O 4A4-22-3 FIG 5-1, RIVET HEAD SHOULD BE LOCATED OPPOSITE SIDE OF (CONTINUED)		001 MNPSA 002 08 003 HB01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36008N
		B	D	306

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE 1980—640-365

36008N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89041 | PAGE 6 OF PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	LOWER DRAG BRACE

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		FINGER ENGAGEMENT. *C/P MOVE P/N NAS1199-9-20			
69	105	MACHINE SLEEVE AS PER TO 4A4-22-3 FIG 5-1 *C/P MOVE		001 MNPRA 002 03 003 BE01	
69	109	MACHINE APEX #8 INBOARD BUSHING *C/P MOVE P/N ST4M130-22004		001 MNPRA 002 03 003 LE02	
69	110	INSTALL APEX INBOARD BUSHING (8) P/N ST4M130-22004 I.D. 1.438/1.439 *C/P MOVE		001 MNPRA 002 03 003 BE01	
69	114	MACHINE O/S APEX INBOARD BOSS *C/P MOVE P/N 7828424-53		001 MNPRA 002 03 003 LE02	
69	115	INSTALL O/S APEX INBOARD BOSS 1.375/1.376 P/N 7828424-53 INBOARD - OUTBOARD FACE TO FACE: 3.258/3.270S/3.3464		001 MNPRA 002 03 003 BE01	
		FLANGE .039/.040/.032 *C/P MOVE			
69	119	MACHINE APEX OUTBOARD BUSH #7 *C/P MOVE P/N ST4M130-22005		001 MNPRA 002 03 003 LE02	
69	120	INSTALL APEX OUTBOARD BUSHING (7) P/N ST4M130-22005 I.D. 1.4380/1.439(*C/P MOVE		001 MNPRA 002 03 003 BE01	
69	124	MACHINE O/S OUTBOARD APEX BOSS *C/P MOVE P/N 7829424-55		001 MNPRA 002 03 003 LE02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36008N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE 1980—640-160

[redacted] WORK CONTROL DOCUMENT (MEDS) | 1. DATE 89041 | PAGE __ OF __ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	LOWER DRAG BRACE

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	125	INSIALL O/S OUTBOARD APEX BOSS 1.438/1.439 P/N 7829424-55 FLANGE .039/.040/.032 *C/P MOVE		001 MNFRA 002 03 003 BEC1	
69	129	MACHINE CYL LUG BUSHING #6 *C/P MOVE P/N ST4M130-22003		001 MNFRA 002 03 003 LEC2	
69	130	INSTALL CYLINDER LUG BUSHING (6) P/N ST4M130-22003 ID 1.375/1.376 *C/P MOVE		001 MNFRA 002 03 003 BEC1	
69	134	MACHINE O/S CYL ATTACH BOSS *C/P MOVE P/N 7829424-57		001 MNFRA 002 03 003 LEC2	
69	135	INSTALL O/S CYL ATTACH BOSS 1.438/1.439 P/N 7829424-57 FLANGE .0393/.0403/.032 OUTSIDE FACE TO FACE		001 MNFRA 002 03 003 BEC1	
		1.8056/1.8132/1.7912 *C/P MOVE			
[redacted]	140 *READ*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL *READING OPERATIONS ONLY		QC1 MNFRA QC2 06 QC3 QA3	
[redacted]	150 *REQD*	FINAL PROJECT VISUAL INSPECTION *C/P MOVE		QC1 MNFRA QC2 06 QC3 QA3	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	3600BN
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

3AB

★ U.S. GOVERNMENT PRINTING OFFICE: 1980—340-160

WORK CONTROL DOCUMENT (MEDS)

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.
	4A4-22-3 4S-1-182	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 *OPTIONAL
F 15 MAIN		

13. SERIAL NUMBER	14 NOUN
	JURY LINK PIN

15. DISPATCH STATION P/N	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED NSN			18. MECHANIC	19. "P"	20. "Q"
68A410756-1001		1620003386530		26338A L / H 26337A R / H			
		COVERNING DIRECTIVES		[illegible] 66-51 [illegible] 65-3			
		BLAST	IAW	[illegible] 1504			
		[illegible]	IAW	[illegible]			
				P/O M01541			
		STRIP	IAW	MIL-STD-871			
		GRIND	IAW	MIL-STD-866			
		TEMPER ETCH	IAW	MIL-STD-867			
		SHOT PEEN	IAW	MIL-S-13165			
		FPI	IAW	MIL-STD-6866			
		CHROME PLATE	IAW	MIL-STD-1501			
				P/O M01541			
		VAC CAD PLATE	IAW	MIL-C-8837			
		CAD PLATE	IAW	MIL-STD-870			
		BAKE	IAW	[illegible]-182			
				MAGI PA 42			
		IVD ALUM PLATE	IAW	MIL-C-83488A			
		ALODINE	IAW	MIL-C-5541			
		**** STEEL 300M 280/300 KSI ****					
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS.					
		THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT					
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATING DISPATCH STATIONS.					
		(CONTINUED)					

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36009N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE 1980-0-311-240

36009N **WORK CONTROL DOCUMENT (MEDS)** 1 DATE 89041 PAGE 2 OF PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	JURY LINK PIN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	[illegible]			
[redacted]	*REQD*	DISASSEMBLE *C/P MOVE		001 MNFSW 002 02 003 LG02 005 X8745199	
[redacted]	*REQD*	DECREASE ONLY *C/P MOVE		001 MNFSW 002 02 003 0G02	
[redacted]	*REQD*	BLAST CLEAN ONLY *C/P MOVE		001 MNFSW 002 03 003 BL0/	
[redacted]	*REQD*	ANY * WK. AT THIS AGY. DATE IN_____ TIME IN_____ DATE OUT_____ TIME OUT_____ *C/P MOVE		001 MNFSW 002 03 003 BK03	
[redacted]	*REQD*	*C/P MOVE	M	001 MNFNA 002 05 003 MS03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36009N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

★ U.S. GOVERNMENT PRINTING OFFICE: 1980—640-266

36009N **WORK CONTROL DOCUMENT (MEDS)** | 1. DATE 89041 | 3. PAGE __ OF __ PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	JURY LINK PIN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		~~END I INSP 001~~		001 MNPRW	
				002 04	
	REQD	PIN OD SMALL END .9980/.9990/.9960		003 EI01	
		~~LARGE O.D. 1.3734/1.3725~~			
		CROSS BOLT HOLE .252/.254/.264 MAX.			
		NOTE: IF NO FURTHER REWORK IS			
		~~REQUIRED ON ROLL PIN~~			
		MUST BE PERFORMED.			
		*C/P MOVE			
~~20~~	~~021~~	~~MAGNA INSPECT *C/P MOVE~~		~~001 MNPRC~~	
				002 03	
				003 DG01	
~~22~~	~~024~~	~~STATIC BAL *C/P MOVE~~		~~001 MNPRC~~	
				002 02	
				003 CS01	
~~23~~	~~026~~	~~FINAL PART *C/P MOVE~~		~~001 MNPRC~~	
				002 02	
				003 CS02	
~~24~~	~~030~~	~~MACHINE CROSS BOLT HOLE~~		~~001 MNPRA~~	
		.244		002 03	
		*C/P MOVE		003 BI01	
~~25~~	~~040~~	~~STRESS RELIEF~~			
		*C/P MOVE		001 02	
				003 BC02	
[redacted]		~~FIRST GRIND PIN SMALL O.D. MIN .9780~~		001 MNPRP	
		*C/P MOVE		002 01	
				003 GE00	
[redacted]		~~1.3675 MIN~~		001 MNPRP	
		*C/P MOVE		002 01	
				003 GE00	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36009N
		B	D	

AFLC FORM 958 NOV. 80 — PREVIOUS EDITION WILL BE USED

311

* U.S. GOVERNMENT PRINTING OFFICE: 1982-360-882/2302

36009N **WORK CONTROL DOCUMENT (MEDS)** 1 DATE 89041 PAGE 4 OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	JURY LINK PIN

15. DISPATCH STATION	16. PERF RCC/OP	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]			M	002 06 003 TE03	
		TIME OUT_____DATE OUT_____ *C/P MOVE			
		* * * * * * * * * N O T E * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *			
265 ✓	070	[illegible] WITHIN 2 HRS OF ETCH DATE IN_____TIME IN_____		[illegible] 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]		*C/P MOVE		001 MNPRC	
		* * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	002 06 003 ML04	
20 ✓	080	[illegible] *C/P MOVE		[illegible] 002 03 003 [illegible]	
22 ✓	070	[illegible] .008/.012 [illegible] *C/P MOVE		[illegible] 002 01 003 SP02	
24 ✓	093	~~PREPARE FOR CHROME PLATE OF PIN~~ O.D. FIXTURE/MASK/ETC. *MECHANIC SIGNOFF REQUIRED——————> *C/P MOVE		~~001 MNPRC~~ 002 02 003 BE01	
25 ✓	097	~~PREPARE PIN O.D. FOR CHROME PLATE.~~ GRIT BLAST *C/P MOVE		~~001 MNPRC~~ 002 01 003 BL04.	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36009N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

312

* U.S. GOVERNMENT PRINTING OFFICE: 1986—480-288

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041 | PAGE 1 OF 3 PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	JURY LINK P/N

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
20 ✓	100	~~CHROME PLATE LARGE O.D. TYPE II~~ CLASS III SUFFICIENT TO GRIND BACK TO .9990. TIME OUT_____DATE OUT_____		~~001 MNPRC~~ 002 02 003 CP01 008 C0010	
		*MECHANIC SIGN-OFF REQUIRED----------> *C/P MOVE			
20 ✓	115	~~CHROME PLATE LARGE O.D. TYPE II~~ CLASS III SUFFICIENT TO GRIND BACK TO 1.374. TIME OUT_____DATE OUT_____		~~001 MNPRC~~ 002 02 003 CP01 008 C0020	
		*MECHANIC SIGN-OFF REQUIRED----------> *C/P MOVE			
20 ✓	115	~~MAKE ENTRE IRON 4 HRS OF CHROME~~ OF CHROME DATE IN_____TIME IN_____		~~001 MNPRC~~ 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
20 ✓	120	~~FINISH GRIND PIN .9990/.9990~~ *C/P MOVE		~~001 MNPRC~~ 002 01 003 GE00	
20 ✓	125	~~FINISH GRIND LARGE O.D. .9991/.9995~~ *C/P MOVE		~~001 MNPRC~~ 002 01 003 GE00	
20 ✓	130	~~BAKE 4 HRS AT 375-400F~~ DATE IN_____TIME IN_____		~~001 MNPRC~~ 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36009N
		B	D	

AFLC FORM 958 NOV. 80 — PREVIOUS EDITION WILL BE USED

3/3

* U.S. GOVERNMENT PRINTING OFFICE: 1983—403-103

36009N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041 | PAGE 6 OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	JURY LINK PIN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		*C/P MOVE			
		* * * * * N O T E * * * * * * *	M	002 06	
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *		003 ML04	
		* * * * * * * * * * * * * * * * *			
2C	[illegible]	[illegible] *C/P MOVE		001 MAINRC	
✓				002 03	
[redacted]				003 DG01	
		*C/P MOVE		001 MAINRC	
		* * * * * * N O T E * * * * * * *	M	002 06	
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *		003 ZS01	
		* * * * * * * * * * * * * * * * *			
22	173	[illegible]		[illegible]	
✓		ALL AREAS TO BE CAD/VAC CAD/IVD PLATED *C/P MOVE		002 01 003 BL04	
23	173	[illegible]		001 MAINRC	
✓		*C/P MOVE		002 02 003 VC01	
[illegible]	[illegible]	[illegible]		[illegible]	
✓		10V 50 DT AT 60 AMPS PER 50 FT *C/P MOVE TIME OUT _____ DATE OUT _____		002 03 003 CA01	
22B	170	BAKE 23 HRS WITHIN 4 HRS OF CAD PLATE		001 MAINRC 002 02 003 BK01	
✓		DATE IN _____ TIME IN _____			
		DATE OUT _____ TIME OUT _____ (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36009N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-165

WORK CONTROL DOCUMENT (MEDS)

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	**14 NOUN**	
	JURY LINK PIN	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
20	175	CHROMATE CONVERSION FOR TYPE II CAD AND TYPE II VAC CAD *C/P MOVE		001 MNFRC 002 02 003 IR01	
		*C/P MOVE		001 MNFRA	
	.65	* * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	002 06 003 ML04	
25	180	VAR. I.V.I.D. ALUM. PLATE CLASS 2 TYPE II NOTE:OPERATION --170 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE MOVE USING I.V.I.D. OPTION. *C/P MOVE		001 MNFRC 002 03 003 IV01	
30	185	ALUMINUM ANO HEAT PLATE CLASS 2A *C/P MOVE		001 MNFRC 002 03 003 TA01	
	190	FINAL PRODUCT INSPECTION OF WORK TO ENSURE COMPLETENESS & ACCURACY		001 MNFRP 002 06	
	REQD	OF ALL PRECEDING OPERATIONS THIS 958		003 SA03	
	200	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNFRP 002 06	
	REQD			003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36009N
		B	D	315

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-168

36010N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041 | PAGE 1 OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.
	4A4-22-3 4S-1-182	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
F 15 MAIN		26338A

13. SERIAL NUMBER	14 NOUN
	LOWER JURY LINK

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 68A410795-1003	NSN [redacted]	G/A 26338A L / H 26337A R / H			
		UNIT COST 70.20			
		GOVERNING DIRECTIVES: AFLCR 66-5 MANOI 66-3			
		BLAST IAW MIL-STD-1[illegible]			
		FPI IAW MIL-STD-[illegible]			
		STRIP IAW MIL-STD-871			
		ANODIZE IAW MIL-A-8625			
		MAGNESIUM ALLOY			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT MUST HAVE BEEN THOROUGHLY TRAINED AND BE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROCESSED (IF APPLIC) FOR [illegible]			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36010N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

☆ U.S. GOVERNMENT PRINTING OFFICE: 1980—640-100

[redacted] WORK CONTROL DOCUMENT (MOD) [redacted] PAGE 2

PAGE ___ OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 *OPTIONAL

13. SERIAL NUMBER	14 NOUN
	LOWER JURY LINK

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		[redacted] (IMMERSION CLEANING) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	SUM-10795-1003			
[redacted]	*REQD*	[redacted] *C/P MOVE		001 MNFGW 002 02 003 LS02 005 X0745199	
[redacted]	*REQD*	CHEM. CLEAN *C/P MOVE		001 MNFGW 002 03 003 AC02	
[redacted]	*REQD*	MAST CLEAN DRY *C/P MOVE		001 MNFGW 002 03 003 BL07	
[redacted]	*REQD*	*C/P MOVE	M	001 MNFNA 002 05 003 ZY05	
[redacted]	*REQD*	[redacted] INSPECT PLANCID BUSHING ID .6875/.6885/.6910 SPOT ATTACH HOLE .312/.292 .317MAX [redacted] BUSHING I.D. 1.3750/1.3760/1.3780 NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FPI MUST BE PERFORMED. *C/P MOVE		001 MNFGW 002 04 003 EI01	
26	030	STRIP ANODIZE *C/P MOVE		001 MNFRC 002 03 003 AN04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36010N
		B	D	312

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980—840-365

36010N

WORK CONTROL DOCUMENT (MEDS)

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN	
	LOWER JURY LINK	

15. DISPATCH STATION	16. PERF RCC/OP	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P" MN/RA	20. "Q"
[redacted]		*C/P MOVE			
		* * * * * * N O T E * * * * * * *	M	002 06	
		IF LAST NDI OPERATION IS COMPLETED*		003 ZA02	
		HERE, TAKE PRODUCTION COUNT *			
		* * * * * * * * * * * * * * * *			
69	042	POLISH SPRING ATTACH		[illegible]	
		HOLE .927 MAX.		002 03	
		C/P MOVE		003 BE01	
69	044	O/S APEX LUG BOSS MAX I.D. .0765		001 MNFRA	
		*C/P MOVE		002 03	
				003 BE01	
69	046	O/S GROUND LUG BOSS MAX I.D.		001 MNFRA	
		.5865		002 05	
		*C/P MOVE		003 BE01	
69	048	O/S DRAG BRACE LUG BOSS MAX I.D.		001 MNFRA	
		1.5315		002 03	
		*C/P MOVE		003 BE01	
69	050	ANGLE TYPE II CLASS I		001 MNFRC	
		*C/P MOVE		002 03	
				003 AS03	
69	052	MACHINE STL APEX FLANGED BUSH			
		*C/P MOVE		002 03	
		P/N S14M130-10006		003 LE02	
69	060	INSTALL STL APEX FLANGED BUSHING		001 MNFRA	
		P/N S14M130-10006 ID .4885/.4865		002 03	
		*C/P MOVE		003 BE01	
69	064	MACHINE O/S [redacted] BUSH		001 MNFRA	
		MOVE		002 03	
		P/N 7829424-51		003 LE02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36010N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-016

360[redacted] WORK CONTROL DOCUMENT (MED) [redacted] 1 DATE [redacted] PAGE [redacted] OF [redacted]

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN	
	LOWER JURY LINK	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	065	~~INSTALL 0/S APEX FLANGE BUSH~~ P/N 7829424-51 I.D. .6875/.6885 FACE TO FACE .9644/.9714/.986 FLANGE .0393/.0403/.032 FIT AT .0005/.0015 *C/P MOVE		001 MNPRA 002 03 003 BE01	
69	067	~~INSTALL STD DRAG BRACE BOSS BUSH~~ *C/P MOVE P/N 68A410778-2001		001 MNPRA 002 03 003 BE01	
69	070	~~HONE STD DRAG BRACE BOSS BUSH~~ P/N 68A410778-2001 ID 1.3750/1.3760 *C/P MOVE		001 MNPRA 002 03 003 HP00	
69	072	~~MACH 0/S DRAG BRACE BUSHINGS~~ *C/P MOVE P/N 7829419-01		001 MNPRA 002 03 003 LE02	
69	073	~~INSTALL 0/S DRAG BRACE BUSH~~ P/N 68A410778-2001 *C/P MOVE			
69	075	~~HONE 0/S DRAG BRACE BOSS BUSH~~ P/N 7829419-01 I.D. 1.3750/1.3760 FIT AT .001/.003 *C/P MOVE		001 MNPRA 002 03 003 HP00	
69	077	~~INSTALL 0/S GROUND BOSS~~ *C/P MOVE P/N 7829423-27		001 MNPRA 002 03 003 BE01	
69	078	~~MACHINE 0/S GROUND BOSS~~ P/N 7829423-27 I.D. .5210/.5215 FIT AT .0005/.001 *C/P MOVE		001 MNPRA 002 03 003 LE02	
[redacted]	080	~~FINAL ACCEPTANCE OF WORK CONTROL~~ DOCUMENT FOR COMPLETENESS, ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNPRA 002 06 003 SA03	
	REQD				

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36010N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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☆ U.S. GOVERNMENT PRINTING OFFICE: 1980—640-100

3601ON WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041 | PAGE 5 OF 5 PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEQ/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	LOWER JURY LINK

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. 001 "P" MNEMONIC	20. "Q"
	REDO	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	3601ON
		B	D	

$20

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980-0-311-240/2

36011N WORK CONTROL DOCUMENT (MED) [redacted]

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC MNPGP	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.
	4A4-22-3 4S-1-182	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
F-15 MAIN		

13. SERIAL NUMBER	14 NOUN
	UPPER JURY LINK

26337A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N		R/N S/N			
68A410794-1006	R/H	162001040358O 26337A R / H			
[redacted]					
		~~GOVERNING INSTRUCTIONS: AFLCR 66-61~~ MANOI 66-3			
		BLAST IAW MIL-STD-1504			
		~~PAINT~~ IAW ~~MIL-STD-1249~~ P/O N01521			
		STRIP IAW MIL-STD-871			
		GRIND IAW MIL-STD-866			
		TEMPER ETCH IAW MIL-STD-867			
		~~SHOT PEEN~~ IAW ~~MIL-S-13165~~			
		FPI IAW MIL-STD-6866			
		CAD IAW MIL-STD-870			
		VAC CAD IAW MIL-C-3883			
		~~CHROME PLATE IAW MIL-STD-1501~~ P/O N01891			
		BAKE IAW 4S-1-182 MAOI 24-12			
		~~VAC 1/2 ALUM PLATE IAW MIL-C-83488A~~			
		ALODINE IAW MIL-C-5541			
		**********STEEL 300M**********			
		**********UNIT COST $2927.07**********			
		~~HAVE BEEN THOROUGHLY TRAINED AND~~ FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS ~~THAT APPLY TO BLOCK~~ 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		W A R N I N G			
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36011N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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★ U.S. GOVERNMENT PRINTING OFFICE: 1980—311-766

36011N1 **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89041 | PAGE 2 OF 3 PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	UPPER JURY LINK

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD - MANDATORY REQUIREMENT IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	6SSA41074-1005 6SSA41074-1006			
[redacted]	*REQD*	[illegible] *C/P MOVE		001 MNFSW 002 02 003 L002 005 X8745199	
[redacted]	*REQD*	[illegible] *C/P MOVE		001 MNFSW 002 03 003 SL01	
[redacted]	*REQD*	[illegible] CLAMP CYLINDER APEX SOCKET TO *C/P MOVE		001 MNFSW 002 03 003 BL01	
[redacted]	*REQD*	[illegible] DATE IN_____ TIME IN_____		001 MNFSW 002 03 003 BK03	
		DATE OUT_____ TIME OUT_____ *C/P MOVE			
[redacted]	*REQD*	*C/P MOVE	M	001 MNFNA 002 05 003 MS03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36011N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-100

36011N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89-11 | 3 PAGE__OF__PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	UPPER JURY LINK

15. DISPATCH	16. PERF RCC/OP	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		~~E AND I INSPECT~~		~~001 MNPRA~~	
				002 04	
	REQD	SPRING ATTACH HOLE .312/.3195 .327 MAX		003 EI01	
		~~LINK OD 1.248/1.249/1.245~~			
		BEARING ID .7495/.7500/.7520			
		~~CYL ROD SOCKET ID 1.375/1.376/1.379~~			
		FLANGED BUSHING ID .6895/.6885/.6910			
		~~GREASE BOSS SLOT .630 .693 MAX~~			
		NOTE: IF NO FURTHER REWORK IS REQUIRED AN ADDITIONAL FMPI ~~MUST BE PERFORMED.~~ *C/P MOVE			
~~69~~	~~021~~	~~REMOVE PIN FROM JURY LINK~~ *C/P MOVE* [redacted]		~~001 MNPRA~~ 002 03 003 BE01	
~~69~~	~~022~~	~~REMOVE BUSHINGS~~ *C/P MOVE		~~001 MNPRA~~ 002 03 003 BE01	
~~69~~	~~023~~	~~POLISH ATTACH HOLE~~ .327 MAX. *C/P MOVE*		~~001 MNPRA~~ 002 03 003 BE01	
~~69~~	~~025~~	~~B/C CYL SOCKET~~ [redacted] *C/P MOVE		~~001 MNPRA~~ 002 03 003 LE02 005 X8633614	
~~69~~	[redacted]	~~MAGNETIC~~ [redacted] USING CARE NOT TO CUT IN[redacted] METAL. PRESS BEARING OUT IAW. (CONTINUED)		~~001 MNPRA~~ 002 03 003 MV00	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36011N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-108

WORK CONTROL DOCUMENT (MEDS)

1. DATE 9041 | PAGE 4 OF PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL/DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	UPPER JURY LINK

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE			
	035	*C/P MOVE		001 MNTRA 002 03 003 BEC1	
	038	REWORK GROUND BOSS SLOT .17 MAX *C/P MOVE*		001 MNTRA 002 03 003 BEC1	
28	040	VAPOR DEGREASE C/P MOVE		001 MNTRA 002 03 003 DGC1	
28	042	STRIP CAL C/P MOVE		001 MNTRC 002 02 003 CSC1	
28	045	STRIP ROD C/P MOVE		001 MNTRC 002 02 003 CSC2	
28	048	STRIP CHROME FROM LINK ID *C/P MOVE		001 MNTRC 002 02 003 SCC2	
6	050	FIRST GRIND LINK OD MIN OD 1.2280 *C/P MOVE		001 MNTRA 002 02 003 GEC4	
		[redacted]		001 MNTRA	
		TIME OUT_____DATE OUT_____ *C/P MOVE	M	002 06 003 TEC3	
		********NOTE******** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * (CONTINUED)			

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				36011N
		B	D	

AFLC FORM 868 NOV. 80 PREVIOUS EDITION WILL BE USED

[redacted]

WORK CONTROL DOCUMENT (MEDS)

1. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEQ/REC	5. DATE ISSUED	6. [illegible]

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL/DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	UPPER JURY LINK

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
[redacted]	070	BAKE 4 HRS WITHIN 8 HRS OF ETCH.		001 MNPRC	
				002 02	
		DATE IN _____ TIME IN _____		003 BK01	
		DATE OUT _____ TIME OUT _____			
		*C/P MOVE			
[redacted]				001 MNPRC	
		*C/P MOVE	M	002 06	
		* * * * * * * * N O T E * * * * * * * *		003 ML04	
		IF LAST NDI OPERATION IS COMPLETED*			
		HERE, TAKE REJECTION COUNT. *			
		* * * * * * * * * * * * * * * * * * *			
26	085	VAPOR DEGREASE *C/P MOVE		001 MNPRC	
				002 03	
				003 DG01	
26	096	SHOT PEEN LINK OP		001 MNPRC	
		.008/.012 A2 100% COVERAGE		002 01	
		*C/P MOVE		003 SP02	
26	096	*MACHINE LINK OD FOR CHROME PLATE		001 MNPRC	
		TYPE I CLASS B. MASK/FIXTURE/ETC.		002 02	
				003 BE01	
		MECHANIC SIGN OFF REQUIRED _____			
		*C/P MOVE			
26	097	PREPARE LINK OD FOR CHROME PLATE.		001 MNPRC	
		GRIT BLAST. *C/P MOVE		002 01	
				003 BL04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36011N
		B	D	

AFLC FORM 958 NOV 80 PREVIOUS EDITION WILL BE USED

WORK CONTROL DOCUMENT (MEDS)

1. DATE 7941 | 2. PAGE __ OF __ PAGES

3. JOB ORDER NO	5. QUANTITY	6. PRODUCTION REQ'RED	7. DATE ISSUED	8. DATE COMPLETED

9. PART NUMBER	10. TECH DATA	11. TYPE SERVICE NO.

12. MODEL/DESIGN SERIES	13. STOCK NUMBER	14. OPTIONAL

15. SERIAL NUMBER	16. NOUN
	UPPER JURY LINK

17. DISPATCH STATION	18. PERF RCC/OP NO	19. WORK TO BE ACCOMPLISHED	20. MECHANIC	21. "P"	22. "S"
28 ✓	100	CHROME PLATE LINK BEFORE CLASS III SUFFICIENT TO GRIND BACK TO 1.249		002 02 003 CP01 008 CO010	
		DATE OUT TIME OUT MECHANIC SIGN OFF REQUIRED *C/P MOVE			
29A ✓	110	BAKE 4 HRS WITHIN 4 HRS OF CHROME DATE IN TIME IN		001 MNPBC 002 02 003 BK01	
		DATE OUT TIME OUT *C/P MOVE			
8 ✓	120	FINISH GRIND LINK OD 1.248/1.249 *C/P MOVE		001 MNPBC 002 02 003 GE04	
29B ✓	130	BAKE 4 HRS AT 350-400F DATE IN TIME IN		001 MNPBC 002 02 003 BK01	
		DATE OUT TIME OUT *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *	M	002 06 003 ML04	
26 ✓	145	VAPOR DEGREASE *C/P MOVE		001 MNPBC 002 03 003 CD01	

23. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	25. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	26. DISPOSITION 340114
		B	D	

WORK CONTROL DOCUMENT (MEDS)

3. JOB ORDER NO	3. QUANTITY	4. PRODUCTION REC/REQ	5. DATE ISSUED	6. DATE REQUIRED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL/DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	UPPER JURY LINK

15. OPERATION	16. PERF RCC/OP	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. 001 "F" MNEMONIC	20. "G"
[redacted]					
		*C/P MOVE	M	002 06	
		* * * * * * * N O T E * * * * * * *		003 ZS01	
		IF LAST NDI OPERATION IS COMPLETED*			
		HERE, TAKE PRODUCTION COUNT. *			
		* * * * * * * * * * * * * * * * * *			
20	130	PRIOR TO CAD/VAC CAD/IVD, GRIT BLAST		001 XU01	
C ✓		ALL AREAS TO BE CAD/VAC CAD/IVD		002 01	
		PLATED. *C/P MOVE		003 BL04	
25	160	CAD PLATE TYPE II CLASS II		001 MNEMO	
C ✓		.055 SQ FT AT 2.75 - 3.85 AMPS		002 02	
		*C/P MOVE		003 CA01	
		TIME OUT_____ DATE OUT_____			
25	162	STRIP AL VACUUM CAD PLATE		001 MNEMO	
C ✓		TYPE II CLASS I		002 02	
		IF BUSHINGS ARE NOT REMOVED		003 VC01	
ACC	165	BAKE 23 HRS WITHIN 4 HRS OF CAD		001 MNEMO	
C ✓		*C/P MOVE		002 02	
				003 BK01	
		DATE IN_____ TIME IN_____			
		DATE OUT_____ TIME OUT_____			
		*C/P MOVE			
25	170	INSPECT		001 MNEMO	
C ✓		*C/P MOVE		002 02	
				003 IR01	
[redacted]					
	.65	*C/P MOVE	M	001 MNEMO	
		* * * * * * * N O T E * * * * * * *		002 06	
		IF LAST NDI OPERATION IS COMPLETED*		003 ML04	
		HERE, TAKE PRODUCTION COUNT. *			
		* * * * * * * * * * * * * * * * * *			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	3601LN
		B	D	

36011N **WORK CONTROL DOCUMENT (MEDS)** 1 DATE 89041 PAGE 8 OF PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEQ/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	UPPER JURY LINK

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	175	IVD PLATE (INITIATED BY PLATING)		001 MNPRC	
		NOTE OPERATION 165 MUST BE ACCOMPLISHED PRIOR TO USING IVD OPTION. C/P MOVE		002 03 003 IVC1	
26	177	ALODINE IVD AREAS (INITIATED BY PLATING) C/P MOVE		001 MNPRC 002 03 003 TAC1	
67	200	INSTALL BEARING IAU 4A4 22 3 *C/P MOVE P/N M81936-1-12			
67	201	MACHINE 6/3 CYL SOCKET BUSHING *C/P MOVE PRESS FIT .001/.003 P/N 7829423-23		001 MNPRA 002 02 003 LEC2	
67	203	INSTALL 6/3 CYL SOCKET BUSHING P/N 7829423-23 *C/P MOVE		001 MNPRA 002 02 003 BEC1	
67	205	MACHINE FINISH SOCKET BUSHING I.D. 1.3750/1.3765 *C/P MOVE		001 MNPRA 002 02 003 LEC2 005 XB633614	
67	206	MACHINE STD APEX BUSHING PRESS FIT .0005/.0015 *C/P MOVE P/N ST4M130-10004		001 MNPRA 002 02 003 LEC2	
67	208	INSTALL STD APEX BUSHING P/N ST4M130-10006 *C/P MOVE		002 02 003 BEC1	
[redacted]		[redacted] APEX FLANGED BUSHING P/N ST4M130-10008 I.D. .6875/.6885 *C/P MOVE		001 MNPRA 002 02 003 HHC0	
[redacted]		[redacted] PRESS FIT .0005/.[redacted] *C/P MOVE		001 MNPRA 002 02 003 LEC2	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36011N
		B	D	

AFLC FORM 988 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—311-[illegible]

36011N WORK CONTROL DOCUMENT (MEDS)

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEQ/ROC	5. DATE ISSUED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	UPPER JURY LINK

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		P/N 7327424-51			
69	215	INSTALL U/S APEX BUSHING		001 MNHRA	
		*C/P MOVE		002 02	
		FIT .0005/.0015		003 BEC1	
		*C/P MOVE			
69	217	HONE U/S APEX BUSHING		001 MNHRA	
		I.D. .6875/.6885		002 02	
		*C/P MOVE		003 HHCC	
	220	FINAL ACCEPTANCE OF WORK CONTROL		001 MNHRP	
		DOCUMENT FOR COMPLETENESS & ACCURACY		002 06	
	REQD	OF ALL PRECEDING OPERATIONS THIS 958		003 SA03	
	230	FINAL PRODUCT VISUAL INSPECTION		001 MNHRP	
		*C/P MOVE		002 06	
	REQD			003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36011N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

36012N **WORK CONTROL DOCUMENT (MEDS)** [redacted]

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEQ RCC	5. DATE ISSUED	6. DATE REQUIRED
		MNPGP		

7. PART NUMBER	8. TECH DATA	9. TYPE SERIAL NO.
	4A4-22-3 4S-1-182	

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
F 15 MAIN		

13. SERIAL NUMBER	14. NOUN
	RETRACT BOLT

263YM

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
68A410	68-1001	[redacted] 26338A L / H 26337A R / H			
		********** UNIT COST: $127.85 **********			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		BLAST IAW MIL-STD-1504			
		~~PMP1 IAW MIL STD 1747~~ P/O N01561			
		STRIP IAW MIL-STD-871			
		GRIND IAW MIL-STD-866			
		~~TEMPER ETCH IAW MIL STD 867~~			
		SHOT PEEN IAW MIL-S-13165			
		FPI IAW MIL-STD-6866			
		CAD IAW MIL-STD-870			
		~~CHROME PLATE IAW MIL STD 1501~~ P/O N61891			
		BAKE IAW 4S-1-182 MnOI 74-12			
		~~DYD RCUM PLATE IAW MIL C 6540A~~			
		ALODINE IAW MIL-C-5541			
		**********STEEL 300M**********			
		~~ALL PERSONNEL INVOLVED IN THE WORK~~ PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY ~~PRACTICES AND HAZARDS CONTAINED IN~~ THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS ~~WILL ALWAYS BE USED IN CONJUNCTION~~ WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR ~~MOVES BETWEEN OPERATIONS/DISPATCH~~ STATIONS. WARNING (CONTINUED)			

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				36012N
		B	D	

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AFLC FORM 988 NOV. 80 PREVIOUS EDITION WILL BE USED

[redacted] WORK CONTROL DOCUMENT (MEDS)

1. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SERVICE	5. DATE STARTED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. [illegible]

10. WORK CENTER SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	RETRACT BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	[illegible]			
[redacted]		DISASSEMBLE *C/P MOVE		001 MNFCW	
	REQD			002 02	
				003 LG02	
				005 XB745199	
[redacted]		CLEARANCE ONLY *C/P MOVE		001 MNFCW	
	REQD			002 02	
				003 DG02	
[redacted]		CLASS CLEAN ONLY *C/P MOVE		001 MNFCW	
	REQD			002 03	
				003 BL17	
[redacted]		[illegible]			
	REQD	DATE IN _____ TIME IN _____		002 03	
				003 BK03	
		DATE OUT _____ TIME OUT _____			
		*C/P MOVE			
[redacted]		*C/P MOVE		001 MNFNA	
	REQD		M	002 05	
				003 MB03	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				36012N
		B	D	

NAVAIR FORM 8115 NOV. 65 PREVIOUS EDITION WILL BE USED

3R1

7.	8. QUANTITY	9. PRODUCTION REQ/REF	10. DATE ISSUED	11. DATE COMPLETED

12.	13. ITEM DATA	14.

15. MODEL/DESIGN SERIES	16. STOCK NUMBER	17. OPTIONAL

18. SERIAL NUMBER	19. NOUN
	RETRACT BOLT

20. OPERATION	21. PERF RCC/OP	22. WORK TO BE ACCOMPLISHED	23. MECHANIC	24. "P"	25. "O"
[redacted]		E MAG I INSPECT		002 04 003 EI01	
	REQD	BOLT SMALL OD .7480/.7490/.7460 *C/P MOVE			
20 ✓	030	VAPOR DEGREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
20 ✓	035	STRIP CAE *C/P MOVE		001 MNPRC 002 02 003 CS01	
20 ✓	040	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
20 ✓	050	STRIP CHROME SMALL O.D. *C/P MOVE		001 MNPRC 002 02 003 SC02	
20 ✓	070	FINAL GRIND SMALL OD MIN OD .7280 *C/P MOVE		001 MNPRC 002 01 003 GE20	
[redacted]		TIME OUT_____DATE OUT_____ *C/P MOVE	M	001 MNPRC 002 06 003 TE03	
20 ✓	090	* * * * * * * * * N O T E * * * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * BAKE 4 HRS WITHIN 8 HRS OF ETCH DATE IN_____TIME IN_____ (CONTINUED)		001 MNPRC 002 02 003 BK01	

26. FINAL DESTINATION		27. COORDINATION/INITIATING RCC SIGNATURE/DATE		28. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36012N
		B	D	

36012N

WORK CONTROL DOCUMENT (MEDS)

1. DATE 79041 | PAGE 4 OF PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	RETRACT BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
		DATE OUT_____ TIME OUT_____ *C/P MOVE			
[redacted]		*C/P MOVE		001 MNFAC	
		* * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *	M	002 06 003 ML04	
25	100	VAPOR DEGREASE *C/P MOVE		001 MNFRC 002 03 003 DG01	
25	110	SHOT PEEN REWORKED AREAS .008/.012 A2 100% COVERAGE *C/P MOVE		001 MNFRC 002 01 003 SP02	
25	120	PREPARE SMALL O.D. FOR CHROME PLATE TYPE 2 CLASS 3 MASK/FIXTURE/ETC *C/P MOVE MECHANIC SIGN OFF REQUIRED_____		001 MNFRC 002 02 003 PE01	
25	125	PREPARE SMALL O.D. FOR CHROME PLATE GRIT BLAST *C/P MOVE		001 MNFRC 002 01 003 BL04	
25	130	CHROME PLATE SMALL O.D. (EXPL 2 CLASS 3 SUFFICIENT TO GRIND BACK TO .7490		001 MNFRC 002 02 003 CP01 008 CD010	
		DATE OUT_____ TIME OUT_____ MECHANIC SIGN OFF REQUIRED_____ *C/P MOVE			
25	140	BAKE 4 HRS WITHIN 4 HRS OF CHROME		001 MNFRC 002 02	
		DATE IN_____ TIME IN_____ (CONTINUED)		003 BK01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36012N
		B	D	

AFLC FORM 858 NOV. 80 PREVIOUS EDITION WILL BE USED

36012N

WORK CONTROL DOCUMENT (MEDS)

1. JOB ORDER NO	2. QUANTITY	3. PRODUCTION RECEIVED	4. DATE RECEIVED	5. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM NOMENCLATURE

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	RETRACT BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "C"
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
[redacted]	160	FINISH GRIND SPACE 35 .7480/.7490 *C/P MOVE		001 MNBRC 002 01 003 GE00	
2CB	170	LAKE 4 NRS AT 850 +00F DATE IN _____ TIME IN _____		001 MNBRC 002 02 003 BK01	
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
[redacted]		* * * * * N O T E * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	N	001 MNBRC 002 06 003 ML04	
2B	185	VAPOR DEGREASE *C/P MOVE		001 MNBRC 002 09 003 DG01	
[redacted]		* * * * * N O T E * * * * * * IF LAST NDI OPERATION IS COMPLETED* TAKE PRODUCTION COUNT *	M	001 MNBRC 002 06 003 ZS01	
2B	195	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TOBE CAD/IVD PLATED *C/P MOVE		001 MNBRC 002 01 003 BL04	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN 36012N
		B	D	

36012N

WORK CONTROL DOCUMENT (MEDS)

[redacted] 4 PAGE 1 OF 1 PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEQUENCE	5. DATE ISSUED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. PRODUCTION SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	RETRACT BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "S"
28	200	CAD PLATE TYPE II CLASS 1A .05 SQ FT AT 2.5 - 3.5 AMPS TIME OUT _____ DATE OUT _____ *C/P MOVE		002 03 003 CA01	
28 ✓	210	BAKE 23 HRS WITHIN 4 HRS OF CAD DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
28 ✓	215	CHROMATE CONVERSION FOR TANK CAD *C/P MOVE		001 MNPRC 002 02 003 IR01	
[redacted]	.65	*C/P MOVE * * * * * N O T E * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNUP 002 06 003 ML04	
28 ✓	223	VAC I.V.D. ALUM PLATE CLASS 2 TYPE II NOTE: OPERATION--210 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING I.V.D. OPTION *C/P MOVE		001 MNPRC 002 03 003 IV01	
28 ✓	227	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNPRC 002 03 003 TA01	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				36012N
		B	D	

AFLC FORM 956 NOV. 80 PREVIOUS EDITION WILL BE USED

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36012N

WORK CONTROL DOCUMENT (MEDS)

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SOURCE	5. DATE ISSUED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-SERIES-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	RETRACT BOLT

15. [redacted]	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19.	20.
	230	FINAL ACCEPTANCE OF WORK CONTROL		001 MNF	GP "0"
	REQD	DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		002 06 003 SA03	
	240	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNF	GP
	REQD			002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		[redacted]
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

[redacted] WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041 | PAGE 1 OF PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC MNPGP	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4A4-22-3 4S-1-182	

10. MODEL/DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
F 15 MAIN		

13. SERIAL NUMBER	14. NOUN
	SPINDLE ASSY

263784

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 68A410	24-1001	[redacted] 26338A L / H 26337A R / H			
		~~UNIT COST: $241.00~~			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		BLAST IAW MIL-STD-1504			
		~~PEEN IAW MIL-STD-1242~~ P/O NO1561			
		STRIP IAW MIL-STD-871			
		GRIND IAW MIL-STD-866			
		~~TEMPER ETCH IAW MIL-STD-867~~			
		SHOT PEEN IAW MIL-S-13165			
		FPI IAW MIL-STD-6866			
		CHROME PLATE IAW MIL-STD-1501 P/O NO1571			
		BAKE IAW 4S-1-182 MAOI 74-12			
		VAC CAD IAW MIL-C-9573A			
		~~ALUM PLATE IAW MIL-STD-871~~			
		IVD ALUM PLATE IAW MIL-C-83488A			
		ALODINE IAW MIL-C-5541			
		~~STEEL 300M~~			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND FAMILIAR WITH ALL PERTINENT SAFE PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.D. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (S/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		(CONTINUED)			

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				36013N
		B	D	

AFLC FORM 888 NOV. 80 PREVIOUS EDITION WILL BE USED

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36013N

WORK CONTROL DOCUMENT (MEDS)

1. DATE 9041 | PAGE 2 OF 3 PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	SPINDLE ASSY

15. DISPATCH STATION	16. PERF. /OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PREVENT INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP			
		[illegible]			
[redacted]		[illegible] *C/P MOVE		001 MNFGU	
	REQD			002 02 003 LG02 005 XB745199	
[redacted]		[illegible] *C/P MOVE		001 MNFGU 002 03 003 SL01	
[redacted]		[illegible] *C/P MOVE		001 MNFGU 002 03 003 BL07	
[redacted]		TAKE 4 HRS AT 250-400F		001 MNFGU	
	REQD	DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		002 03 003 BK03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36013N
		B	D	

36013N WORK CONTROL DOCUMENT (MEDS)

1. DATE 9041 | PAGE 3 OF PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL/DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	SPINDLE ASSY

15. DISPATCH	16. PERF RCC/OP	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P" MNE NA "Q"	20.
[redacted]		*C/P MOVE	M	002 05 003 MS03	
	REQD				
[redacted]		FNL I INSPECTION		001 MNPSW	
	REQD	LARGE OD .6230/.6240/.6250		002 04 003 EI01	
		SMALL OD .4500/.4990/.4995			
		BUSHINGS ID .3750/.3760/.3770 *C/P MOVE			
26	024	MAJOR DECREASE *C/P MOVE		001 MNPRC 002 03 003 DB01	
[redacted]					
26	026	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
[redacted]					
26	028	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
[redacted]					
26	030	B/S BUSH BORE MAX ID .5[illegible] *C/P MOVE		001 MNPRA 002 03 003 BE01	
26	040	STRIP LARGE OD *C/P MOVE		001 MNPRC 002 02 003 SC02	
26	050	STRIP SMALL OD *C/P MOVE		001 MNPRC 002 02 003 SC02	
[redacted]		[redacted] *C/P MOVE		001 MNPRP 002 01 003 GE00	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN 36013N
		B	D	

AFLC FORM 988 NOV. 80 PREVIOUS EDITION WILL BE USED

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[redacted] WORK CONTROL DOCUMENT (MEDS)

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEQUENCE	5. DATE SCHED	6. DATE COMPLETED

7. RAW NUMBER	8. TECH DATA	9. TYPE SERIAL NO.

10. MODEL/DESIGN/SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	SPINDLE ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P" MNPRP "S"	20.
[redacted] ✓	070	FIRST GRIND SHEET 60 MIN OR 4700		001 MNPRP	
		*C/P MOVE		002 01	
				003 GE00	
[redacted]				001 MNPNA	
		*C/P MOVE	M	002 06	
		* * * * * * * N O T E * * * * * * *		003 TE03	
		IF LAST NDI OPERATION IS COMPLETED*			
		HERE, TAKE PRODUCTION COUNT. *			
		* * * * * * * * * * * * * * * * *			
265 ✓	070	BAKE 4 HRS WITHIN 8 HRS OF ETCH		001 MNPRP	
				002 02	
		DATE IN _____ TIME IN _____		003 BK01	
		DATE OUT _____ TIME OUT _____			
		*C/P MOVE			
[redacted]				001 MNPNA	
		*C/P MOVE	M	002 06	
		* * * * * * * N O T E * * * * * * *		003 ML04	
		IF LAST NDI OPERATION IS COMPLETED*			
		HERE, TAKE PRODUCTION COUNT. *			
		* * * * * * * * * * * * * * * * *			
26 ✓	100	VAPOR BLAST ~~*C/P MOVE~~		001 MNPRP	
				002 03	
				003 DG01	
26 ✓	110	SHOT PEEN REWORKED AREAS		001 MNPRP	
		.008/.012 A2 100% COVERAGE		002 01	
		*C/P MOVE		003 SP02	
26 ✓	110	PREPARE OP FOR CHROME PLATE TYPE II		001 MNPRP	
		CLASS III, MASK/FIXTURE/ETC.		002 02	
		*C/P MOVE		003 EE01	
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36013N
		B	D	

AFLC FORM 988 NOV. 80 PREVIOUS EDITION WILL BE USED

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WORK CONTROL DOCUMENT (MEDS)

1. DATE 79041 | PAGE 5 OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEQ/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	SPINDLE ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		~~MECHANIC SIGN OFF REQUIRED~~			
28	117	~~PREPARE OD FOR CHROME, GRIT BL. ST.~~ *C/P MOVE		~~001 MNFRC~~ 002 01 003 BL04	
28	120	~~CHROME PLATE LARGE O.D. TYPE II~~ CLASS III SUFFICIENT TO GRIND BACK TO .6240		~~001 MNFRC~~ 002 02 003 CP01 008 CC010	
		DATE OUT_____ TIME OUT_____ MECHANIC SIGN OFF REQUIRED_____ *C/P MOVE			
28	130	~~CHROME PLATE SMALL O.D TYPE II~~ CLASS III SUFFICIENT TO GRIND BACK TO .498/.499		~~001 MNFRC~~ 002 02 003 CP01 008 CC020	
		DATE OUT_____ TIME OUT_____ MECHANIC SIGN OFF REQUIRED_____ *C/P MOVE			
28D	140	~~BAKE 4 HRS WITHIN 4 HRS OF CHROME~~ PLATE DATE IN_____ TIME IN_____		~~001 MNFRC~~ 002 02 003 EX01	
		DATE OUT_____ TIME OUT_____ *C/P MOVE			
[redacted]	150	[redacted] OD .6230/.6240 *C/P MOVE		001 MNFRB 002 01 003 GE00	
[redacted]		[redacted] O.D. .498/.499 *C/P MOVE		001 MNFRB 002 01 003 GE00	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36013N
		B	D	

AFLC FORM 958 NOV. 80 — PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—311-246

[redacted] WORK CONTROL DOCUMENT [redacted]

4. PRODUCTION SOURCE	5. DATE SCHED	6. DATE REQUIRED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIES NO

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	SPINDLE ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P" MAN RC	20. "Q"
[redacted]	170	TAKE 4 HRS AT [redacted]		001 MNFRC	
		DATE IN_____TIME IN_____		002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]		[redacted] *C/P MOVE		001 MNFRC NA	
		* * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *	M	002 06 003 ML04	
25	177	VAPOR DEGREASE *C/P MOVE		001 MNFRC	
[redacted] ✓				002 03 003 DG01	
[redacted]		[redacted] *C/P MOVE		001 MNFRC NA	
		* * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *	M	002 06 003 ZS01	
25	181	PREP TO PLATE [redacted]		001 MNFRC	
[redacted] ✓		ALL AREAS TO BE CAD/VAC CAD/IVD PLATED. *C/P MOVE		002 01 003 BL04	
25	183	VAC CAD PLATE IF PUSH WERE NOT		001 MNFRC	
[redacted] ✓		REMOVED. *C/P MOVE		002 02 003 VC01	
25	185	CAD PLATE		001 MNFRC	
[redacted] ✓		0.033 SQ FT AT 1.6 - 2.3 AMPS DATE OUT_____TIME OUT_____ (CONTINUED)		002 03 003 CA01	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				36013N
		B	D	

AFLC FORM 956 NOV. 80 PREVIOUS EDITION WILL BE USED

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36013N **WORK CONTROL DOCUMENT (MEDS)** 1 DATE 89041 | PAGE 7 OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. TYPE SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	SPINDLE ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
		~~*C/P MOVE~~			
~~25X~~ ✓	~~197~~	~~BAKE 25HRS AT 350 400F WITHIN 4HRS~~ OF CAD PLATE DATE IN_____ TIME IN_____ ~~DATE OUT_____ TIME OUT_____~~ *C/P MOVE		~~001 MNFRC~~ 002 02 003 BK01	
		~~*C/P MOVE~~		~~001 MNFRC~~	
	965	* * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *	M	002 06 003 ML04	
~~20~~ ✓	~~191~~	~~IRIDITE *C/P MOVE~~ * * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *		~~001 MNFRC~~ 002 02 003 IR01	
~~20~~ ✓	~~195~~	~~VAC IVD ALUM PLATE CLASS 2 (14A, 1)~~ NOTE: OPERATION 187 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE USING IVD OPTION. ~~*C/P MOVE~~		~~001 MNFRC~~ 002 03 003 IV01	
~~26~~ ✓	~~195~~	~~ALODINE IVD ALUM PLATE CLASS 1A~~ *C/P MOVE		~~001 MNFRC~~ 002 03 003 TA01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36013N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980-340-365

[redacted] WORK CONTROL DOCUMENT (MEDIUM) | 1. DATE [redacted] | PAGE 1 OF 1 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEQ/REQ	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL/DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	SPINDLE ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
[redacted]	197	[redacted] *C/P MOVE P/N ST4M130-06003		001 MNFRA 002 003 LL	
[redacted]	200	[redacted] 6003 ID .3750/.3760 *C/P MOVE		001 MNFRA 002 03 003 BE01	
[redacted]	204	MACHINE O/S BUSHING *C/P MOVE P/N 7829424-65		001 MNFRA 002 03 003 LE02	
[redacted]	205	INSTALL O/S BUSH [redacted] 65 ID .375/.3760 FIT .0005/.001 *C/P MOVE		001 MNFRA 002 03 003 BE01	
[redacted]	207	PAINT & TAG *C/P MOVE		001 MNFGP 002 09 003 WB03	
[redacted]	210 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNFGP 002 06 003 SA03	
[redacted]	220 *REQD*	FINAL PROFILE VISUAL INSPECTION *C/P MOVE		001 MNFGP 002 06 003 SA03	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				36013N
		B	D	

AFLC FORM 958 NOV. 80 — PREVIOUS EDITION WILL BE USED

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3. JOB ORDER NO	5. QUANTITY	4. PRODUCTION SHOP/DEPT MNPGP	5. DATE ISSUED	6. DATE [illegible]
7. PART NUMBER	8. TECH DATA 4A4-22-3 4S-1-182			9. ITEM NOMENCLATURE
10. MODEL/DESIGN SERIES F-15 MAIN	11. STOCK NUMBER	12. OPTIONAL		
13. SERIAL NUMBER	14. NOUN SWIVEL CRANK DRAG BOLT	26375A		

16. DISPATCH STATION P/N	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]	1041	P.S.L.S.T. 26336A L / H 26337A R / H			
		********** UNIT COST: $ **********			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANDI 66-3			
		BLAS. IAW MIL-STD-1504			
		MAGNETIC PART IAW MIL-STD-1949 P/O NO1561			
		STRIP IAW MIL-STD-871			
		GRIND IAW MIL-STD-866			
		TEMPER ETCH IAW MIL-STD-867			
		FPI IAW MIL-STD-6866			
		CAD IAW MIL-STD-870			
		CHROME PLATE IAW MIL-STD-1501 P/O N61371			
		BAKE IAW 4S-1-182 MADI 74-12			
		HEAT TREAT 280,000/300,000 PSI			
		IVD ALUM PLATE IAW MIL-C-83488A			
		ALODINE IAW MIL-C-5541			
		**********STEEL 300M**********			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		(CONTINUED)			

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				36014N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

[redacted] WORK CONTROL DOCUMENT [redacted]

1. JOB ORDER NO	2. QUANTITY	4. REDUCTION SERIES	5. DATE ISSUED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. [illegible]

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	SWIVEL CRANK DRAG BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	50A410697 1001			
[redacted]	*REQD*	[redacted]TRANSVEHICLE *C/P MOVE		001 MNFGW 002 02 003 LG02 005 X8745199	
[redacted]	*REQD*	[redacted]CHEM CLEAN *C/P MOVE		001 MNFGW 002 03 003 SL01	
[redacted]	*REQD*	[redacted]GLASS CLEAN ONLY *C/P MOVE		001 MNFGW 002 03 003 BL07	
[redacted]	*REQD*	[redacted]BAKE 4 HRS AT 350-400F DATE IN_____TIME IN_____ DATE OUT_____TIME OUT_____ *C/P MOVE		001 MNFGW 002 03 003 BK03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36014N
		B	D	

AFLC FORM 956 NOV. 80 PREVIOUS EDITION WILL BE USED

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WORK CONTROL DOCUMENT (MEDS)

1. DATE 9041 | 2. [redacted]

3. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	SWIVEL CRANK DRAG BOLT

15. DISPATCH	16. PERF RCC/OP	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "S"
[redacted]		*C/P MOVE	M	001 MNPNA	
	REQD			002 05	
				003 MS03	
[redacted]		E AND I INSPECT		001 MNPBW	
	REQD	BOLT OD 1.4355/1.4365/1.4330		002 04	
				003 EI01	
		CLEARANCE BUSHINGS .500/.501/.502			
		*C/P MOVE			
26	024	WASH OR DEGREASE *C/P MOVE		001 MNPRC	
				002 03	
				003 DG01	
25	020	STRIP CAD *C/P MOVE		001 MNPRC	
				002 02	
				003 CS01	
25	020	STRIP RUST *C/P MOVE		001 MNPRC	
				002 02	
				003 CS02	
24	030	B/S BUNGEE BOSS MAX ID .6901		001 MNPRA	
		*C/P MOVE		002 03	
				003 BE01	
25	040	STRIP ELECTRO LESS NIC CU		001 MNPRC	
		*C/P MOVE		002 02	
				003 SC02	
[redacted]		RECENTER		001 MNPRA	
		*C/P MOVE		002 03	
				003 LE02	
[redacted]		[redacted]		001 MNPRP	
		1.4160 MIN OD		002 02	
		*C/P MOVE		003 GE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENTATION
DISPATCH	FUNCTIONAL CODE	A	C	36014N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

[redacted] WORK CONTROL DOCUMENT [redacted]

3. JOB ORDER NO	5. QUANTITY	4. PRODUCTION SOURCE	6. DATE OPEN	[redacted]

7. PART NUMBER	8. TECH DATA	[redacted]

10. WORK/DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	SWIVEL CRANK DRAG BOLT

15. DISPATCH	16. PERF RCC/SP	17. [redacted] K TO BE ACCOMPLISHED	18. MECHANIC	19. 20. "P" MNE NA "S"
		TIME OUT_____DATE OUT_____ *C/P MOVE	M	002 06 003 TE 3
		* * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *		
26R ✓ [redacted]	070	BAKE 4 HRS WITHIN 8 HRS OF ETCH DATE IN_____TIME IN_____		001 MNE RC 002 02 003 BK 1
		DATE OUT_____TIME OUT_____ *C/P MOVE		
[redacted]		*C/P MOVE * * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * * * * * * * * * * * * * * * * * * *	M	001 MNE NA 002 06 003 ML 4
26 ✓ [redacted]	080	VAPOR DEGREASE *C/P MOVE		001 MNE RC 002 03 003 DG 1
26 ✓ [redacted]	090	SHOT PEEN PIN TO .006/.012 AI ±00% COVERAGE *C/P MOVE		002 01 003 SP 2
26 ✓ [redacted]	095	PREPARE PIN FOR CHROME PLATE TYPE II CLASS III. MASK/FIXTURE/ETC *C/P MOVE MECHANIC SIGN OFF REQUIRED_____		001 MNE RC 002 02 003 BE 1
26 ✓ [redacted]	097	PREPARE PIN O.D. FOR CHROME PLATE, GRIT BLAST. *C/P MOVE		001 MNE RC 002 01 003 BL 4

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENTATION 36014N
		B	D	

AVLC FORM 358 NOV. 80 PREVIOUS EDITION WILL BE USED

1. JOB ORDER No.	3. QUANTITY	4. PRODUCTION SEQUENCE	5. DATE [illegible]	6. [illegible]

7. PART NUMBER	8. TECH DATA	9. [illegible]

10. MODEL/DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	SWIVEL CRANK DRAG BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19.	20.
26 ✓	100	CHROME PLATE PIN TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 1.4365		001 "P" MNEMONIC "O" 002 02 003 CP01 008 CD010	
		DATE OUT TIME OUT MECHANIC SIGN OFF REQUIRED *C/P MOVE			
26B ✓	110	BAKE 4 HRS WITHIN 4 HRS OF CHROME		001 MNEMONIC 002 02 003 BK01	
		DATE IN TIME IN			
		DATE OUT TIME OUT *C/P MOVE			
[redacted]	120	~~FINISH GRIND PIN OD~~ 1.4355/1.4365 *C/P MOVE		001 MNEMONIC 002 02 003 GE01	
26B ✓	130	BAKE 4 HRS		001 MNEMONIC 002 02 003 BK01	
		DATE IN TIME IN			
		DATE OUT TIME OUT *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* ~~HERE, TAKE PRODUCTION SHOT~~ *	M	002 06 003 ML04	
26 ✓	145	VAPOR DEGREASE *C/P MOVE		001 MNEMONIC 002 03 003 DG01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36014N
		B	D	

[redacted] CONTROL DOCUMENT (MEDS)

1. JOB ORDER NO	2. QUANTITY	4. PRODUCTION REQ/RCD	5. DATE ISSUED	6. DATE COMPLETED

7. PART NUMBER	8. ITEM DATA	9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	SWIVEL CRANK DRAG BOLT

15. DISPATCH	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "S"
[redacted]		C/P MOVE	M	001 MNFNA	
		* * * * * * * N O T E * * * * * * *		002 06	
		IF LAST NDI OPERATION IS COMPLETED*		003 ZS01	
		HERE, TAKE PRODUCTION COUNT. *			
		* * * * * * * * * * * * * * * * * *			
25 ✓	155	PRIOR TO CAD/IVD, GRIT BLAST ALL		001 MNFRC	
		AREAS TO BE CAD/IVD PLATED.		002 01	
		*C/P MOVE		003 BL04	
25 ✓	160	CAD PLATE TYPE I CLASS II		001 MNFRC	
		.15 SQ FT AT 7.5 - 10.5 AMPS		002 03	
				003 CA01	
		TIME OUT_____DATE OUT_____			
		*C/P MOVE			
25D ✓	170	BAKE 23 HRS WITHIN 4 HRS OF CAD		001 MNFRC	
				002 02	
		DATE IN_____TIME IN_____		003 BK01	
		DATE OUT_____TIME OUT_____			
		*C/P MOVE			
[redacted]		C/P MOVE	M	002 06	
	165	* * * * * * * N O T E * * * * * * *		003 ML04	
		IF LAST NDI OPERATION IS COMPLETED*			
		HERE, TAKE PRODUCTION COUNT. *			
		* * * * * * * * * * * * * * * * * *			
26 ✓	180	VAC IVD ALUM PLATE CLASS 2 TYPE II		001 MNFRC	
		NOTE: OPERATION 170 MUST BE		002 03	
		ACCOMPLISHED IF PRIOR PLATING REWORK		003 IV01	
		(CONTINUED)			

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN 36014N
		B	D	

AFLC FORM 988 NOV. 80 PREVIOUS EDITION WILL BE USED

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WORK CONTROL DOCUMENT (MEDS)

1. DATE [redacted] | PAGE [redacted] OF [redacted] PAGES

3. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SOURCE	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	SWIVEL CRANK DRAG BOLT

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
		IS DONE, BEFORE USING IVE OPTION.			
28 ✓	187	ALODINE IVE ALUM PLATE GLASS 1A *C/P MOVE		001 MNFRC 002 03 003 TA01	
87 J	189	MACHINE FLANGED [redacted] *C/P MOVE P/N ST4M130-08002		001 MNFRA 002 03 003 LE02	
87 J	190	INSTALL FLANGED [redacted] ST4M130-08002 ID .5007.501 *C/P MOVE		001 MNFRA 002 03 003 BE01	
87 J	194	MACHINE O/D BUNGEE [redacted] *C/P MOVE P/N 7829424-67		001 MNFRA 002 03 003 LE02	
87 J	195	INSTALL O/D BUNGEE [redacted] P/N 7829424-67 ID .5007.501 FIT .0005/.0015 *C/P MOVE		001 MNFRA 002 03 003 BE01	
[redacted]	200 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNFSP 002 06 003 SA03	
[redacted]	210 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNFSP 002 06 003 SA03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENTATION
DISPATCH	FUNCTIONAL CODE	A	C	36014N
		B	D	

AFLC FORM 958 NOV. 80 — PREVIOUS EDITION WILL BE USED

36016N

WORK CONTROL DOCUMENT (MEDS)

1. DATE 89041 | PAGE 1 OF __ PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC MNP0P	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4A4-22-3 4S-1-182	

10. MODEL/DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL
F15 MAIN		263784

13. SERIAL NUMBER	14. NOUN
	COLLAR ASSY

15. DISPATCH STATION P/N	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED NSN	O/H	18. MECHANIC	19. "P"	20. "O"
[redacted]		[redacted]	[redacted]			
68A410733-1002		7H 1620003386559	26337A R / H			

~~********** UNIT COST: $2750.00 **********~~

GOVERNING DIRECTIVES: AFLCR 66-51
MANCI 66-3

BLAST IAW MIL-STD-1504

~~PHPI IAW MIL-STD-1949~~
P/O N01581

BAKE IAW 4S-1-182
MADI 74-12

~~SRIND IAW MIL-STD-866~~

CAD IAW MIL-STD-870

IVD ALUM PLATE IAW MIL-C-83488A

ALODINE IAW MIL-C-5541

~~VAC CAD IAW MIL-C-8837~~

TEMPER ETCH IAW MIL-STD-867

SHOT PEEN IAW MIL-S-13165

~~**** **** STEEL 200/300 KSI ****~~

ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT ~~HAVE BEEN THOROUGHLY TRAINED AND ARE~~ FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND ~~T.O. SUPPLEMENTS REFERENCED. THE~~ APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.

~~*COMPONENTS WILL BE THOROUGHLY~~ CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.

WARNING

MANY OF THE FOLLOWING REPAIR
(CONTINUED)

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				36016N
		B	D	

AFLC FORM 988 NOV. 80 PREVIOUS EDITION WILL BE USED

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[redacted] CONTROL DOCUMENT [redacted] PAGE 2 OF [redacted]

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/ROC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	COLLAR ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	68A410733-1001 68A410733-1002			
[redacted]	*REQD*	DISASSEMBLE *G/P MOVE		001 MNFGW 002 02 003 LG02 005 XB745199	
[redacted]	*REQD*	CHEM CLEAN *G/P MOVE		001 MNFGW 002 03 003 SL01	
[redacted]	*REQD*	CHART CLEAN ONLY *G/P MOVE		001 MNFGW 002 03 003 BL01	
[redacted]	*REQD*	BAKE 4 HRS AT 350-400F DATE IN_____TIME IN_____ DATE OUT_____TIME OUT_____		001 MNFGW 002 03 003 BK03	
[redacted]	*REQD*	*G/P MOVE	M	001 MNFNA 002 05 003 MS03	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				36016N
		B	D	

AFLC FORM 956 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980—340-165

36016N — WORK CONTROL DOCUMENT (MED)

1 DATE 89041 | 3 PAGE __ OF __ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	COLLAR ASSY

15. DISPATCH	16. PERF RCC/OP	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P" MNE CW "Q"	20.
		E & I		001	
	REQD	BUSHING ID #17 & 18 5.6265/5.6275/5.6301		002 04 003 EI01	
		BASE METAL 3.765/3.7664 FACE TO FACE 2.620/2.625/2.604 FLANGE TYPICAL .039/.040/.031			
		TORQUE ARM LEG BUSHING #17 I.D. 1.118/1.1185/1.121 BASE METAL 1.219/1.2204 FACE TO FACE 3.624/3.625/3.603 FLANGE .061/.060/.058 .056/.065/.048			
		COLLAR SPINDEL BUSHINGS #15 TOP FACE M .625/.626/.629 FLANDE M .893/.0903/.0813 #16 BOTTOM FACE N .500/.501/.504 FLANGE (N) .0593/.0603/.0513 BASE METAL TOP .750/.7515 BOTTOM .625/.6265 FACE TO FACE 2.1392/2.1616 *C/P MOVE			
25	020	WIPER GREASE *C/P MOVE		001 MNEPC 002 03 003 B001	
		E & I		001 002 02 003 C301	
26	020	STRIP RUST *C/P MOVE		001 MNERC 002 02 003 C302	
		[redacted] NOT TO EXCEED 5.767/1 MAX *C/P MOVE		001 MNERA 002 03 003 LE02 005 XB633615	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				36016N
		B	D	

AFLC FORM 988 NOV. 80 — PREVIOUS EDITION WILL BE USED

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36016N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 8041 | 4 PAGE ___ OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	COLLAR ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P" MN/RA	20. "Q"
69	040	HONE TORQUE ACTUATE AS REQUIRED NOT TO EXCEED 1.284 MAX *C/P MOVE		001 MNRRA 002 03 003 BE01	
69	050	MACHINE SPINDLE LUG UPPER #1 AS REQUIRED NOT TO EXCEED .815 *C/P MOVE		001 MNRRA 002 03 003 MV00	
69	060	MACHINE SPINDLE LUG LOWER #1 AS REQUIRED NOT TO EXCEED .6961 *C/P MOVE		001 MNRRA 002 03 003 BE01	
[redacted]		DATE OUT _____ TIME OUT _____ *C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *	M	001 MNRRA 002 06 003 TE03	
26	070	ETCH DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____		001 MNRRC 002 02 003 BK01	
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *	M	002 26 003 ML04	
26	075	VAPOR DEGREASE *C/P MOVE		001 MNRRC 002 03 003 DG01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36016N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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☆ U.S. GOVERNMENT PRINTING OFFICE 1980—640-000

36016N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041 | PAGE 5 OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	COLLAR ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
28 ✓	100	~~SHOT PEEN~~ .008/.012 A2 100% COVERAGE *C/P MOVE		001 MNFRC 002 01 003 SP02	
28 ✓	105	~~PRIOR TO CAD/VAC CAD/IVD, GRIT BLAST~~ ALL AREAS TO BE CAD/VAC CAD/IVD. *C/P MOVE		001 MNFRC 002 01 003 BL02	
28 ✓	110	~~CAD PLATE TYPE 2 CLASS 2 TYPE SR~~ AT 37.5 - 52.5 AMPS *C/P MOVE		001 MNFRC 002 02 003 CA01	
28 ✓	120	~~VAC CAD TYPE 2 CLASS 1~~ IF BUSHINGS ARE NOT REMOVED *C/P MOVE		001 MNFRC 002 02 003 VC01	
28 ✓	130	~~BAKE 23 HRS WITHIN 4 HRS OF TANK CAD~~ DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNFRC 002 02 003 BK01	
28 ✓	135	~~CHROMATE CONVERSION COATING FOR TYPE~~ 2 CAD PLATE *C/P MOVE		001 MNFRC 002 02 003 IR01	
[redacted]	165	~~* * * * * N D I * * * * * *~~ IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *		002 04 003 RL04	
28 ✓	137	~~VAC IVD ALUM PLATE CLASS 2 TYPE II~~ NOTE: OPERATION 130 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK (CONTINUED)		001 MNFRC 002 03 003 IV01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36016N
		B	D	

AFLC FORM 958 NOV. 80 — PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—340-240

36016N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89041 | 6 PAGE__OF__PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	COLLAR ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		IS DONE, BEFORE USING IVD OPTION. *C/P MOVE			
26	138	ALIGNING IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNFRA 002 03 003 TAC1	
27	139	INSTALL COLLAR BUSHING STD *C/P MOVE P/N 68A410645-2003 P/N 68A410644-2001		001 MNFRA 002 03 003 BEC1	
28	140	MACHINE COLLAR BUSHING STD P/N TOP 68A410645-2003 BOTTOM 68A410644-2001 .0001/.0025 FIT - FACE TO FACE 2.620/2.625 FLANGE .039/.040 INLINE TO 5.6265/5.6275 I.D. *C/P MOVE		001 MNFRA 002 03 003 LEC2	
29	148	MACHINE COLLAR BUSHING P/N7926302-01 P/N7829424-89		001 MNFRA 002 03 003 LEC2	
30	149	INSTALL COLLAR BUSHING *C/P MOVE P/N 7926302-01 P/N 7829424-89		001 MNFRA 002 03 003 BEC1	
31	150	MACHINE COLLAR BUSHING TOP 7926302-01 BOTTOM 7829424-89 .0001/.0025 FIT - FACE TO FACE 2.626/2.625 FLANGE .039/.040 INLINE TO 5.6265/5.6275 I.D. *C/P MOVE		001 MNFRA 002 03 003 LEC2	
[redacted]		[redacted]5 TOP P/N 314A150-10001 FACE TO FACE 2.1392/2.1616 ID .625/.626 FLANGE (CONTINUED)		001 MNFRA 002 03 003 BEC1	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36016N
		B	D	

★ U.S. GOVERNMENT PRINTING OFFICE: 1980—344-165

36016N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041 | PAGE __ OF __ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN	
	COLLAR ASSY	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	-	*C/P MOVE			
69	189	MACHINE SPINDLE BUSHING #15 *C/P MOVE P/N 75-9424-05		001 MNFRA 002 03 003 LE01	
69	190	INSTALL SPINDLE BUSHING OD #15 TOP P/N 7829424-85 FACE TO FACE 2.1392/2.1616 ID .625/.626 FLANGE (N) .0592/.0903		002 03 003 BE01	
69	189	MACHINE SPINDLE LUG BUSH O/S #16 *C/P MOVE P/N 78294.4-82		001 MNFRA 002 03 003 LE02	
69	190	INSTALL SPINDLE LUG BUSHING OD #16 BOTTOM P/N 7829424-83 FACE TO FACE 2.1392/2.1616 ID .500/.501 FLANGE (N) .0593/.0603 *C/P MOVE		002 03 003 BE01	
69	189	MACHINE [redacted] #18 *C/P MOVE P/N 68A410636-2002		001 MNFRA 002 03 003 LE02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36016N
		B	D	

AFLC FORM 958 NOV. 80 — PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1988-548-265

36016N WORK CONTROL DOCUMENT (MEDS)

1. DATE 89041 | 8 8 PAGE OF PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	COLLAR ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
07	200	INSTALL TORQUE ARM LUG BUSHING STD #19 P/N 38A410836-2001 FACE TO FACE 3.6241/3.625 ID 1.118/1.1185 INCLINE FLANGE VIEWED FROM TOP LEFT (J) .041/.068 RIGHT (K) .056/.065 *C/P MOVE		001 MNTRA 002 03 003 BE01	
07	209	MACHINE TORQUE ARM LUG PUSH O/S #1 *C/P MOVE P/N 7829421-01		001 MNTRA 002 03 003 LE02	
07	210	INSTALL TORQUE ARM LUG BUSHING O/S #19 P/N 7829421-01 FACE TO FACE 3.6241/3.625 ID 1.118/1.119 INLINE FLANGE VIEWED FROM TOP LEFT (J) .041/.068 RIGHT (K) .056/.065 *C/P MOVE		001 MNTRA 002 03 003 BE01	
	READ	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 956		001 MNTRA 002 06 003 SA03	
	END	FINAL PRODUCT WEIGHT ENTRY *C/P MOVE		001 MNTRA 002 03 003 [illegible]	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36016N
		B	D	

AFLC FORM 956 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-[illegible]

36019N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041 | PAGE 1 OF __ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.
	4A4-22-3 4S-1-182	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
F-15 MAIN		

13. SERIAL NUMBER	14 NOUN
	JURY BRACE APEX PIN

263784

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
T/N 68A410755-2005		NSN G/A [redacted] / H 26337A R / H			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		BLAST IAW MIL-STD-1504			
		REV LAD IAW MIL-STD-870			
		[illegible] IAW MIL-S-[illegible]			
		MAGI IAW MIL-STD-1949 P/O NO1561			
		STRIP IAW MIL-STD-271			
		[illegible] IAW MIL-STD-[illegible]			
		APEX ETCH IAW MIL-STD-867			
		SHOT PEEN IAW MIL-S-13165			
		FPI IAW MIL-STD-6866			
		CHROME PLATE IAW MIL-STD-1501 P/O R61771			
		SAFE IAW 4S-1-182 MAOI 74-12			
		[illegible] IAW MIL-S-[illegible]			
		ALODINE IAW MIL-C-5541			
		********STEEL 300M******** ****UNIT COST $331.56*******			
		[illegible] INVOLVED IN THE [illegible] PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND [illegible]			
		THE LATEST TECHNICAL ORDERS AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLIC- ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36019N
		B	D	

AFLC FORM 958 NOV. 80 — PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1988—548-129

[redacted] WORK CONTROL DOCUMENT (MEDS) [redacted]

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	JURY BRACE APEX PIN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		"WARNING" MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PREVENT INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	CDA410755 2005			
[redacted]		DISASSEMBLE *C/P MOVE		001 MNFGW 002 02 003 L002 005 XB745199	
[redacted]	*REQD*	CHECK CLEAN *C/P MOVE		001 MNFGW 002 03 003 SL01	
[redacted]	*REQD*	[redacted]		002 03 003 BL07	
[redacted]	*REQD*	BAKE 4HRS AT 350-400F DATE IN_____TIME IN_____		001 MNFGW 002 03 003 BK03	
		DATE OUT_____TIME OUT_____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36019N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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★ U.S. GOVERNMENT PRINTING OFFICE: 1980—640-165

36019N

WORK CONTROL DOCUMENT (MEDS)

1. DATE 89041 | PAGE 3 OF 4 PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER

14. NOUN: JURY BRACE APEX PIN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	19. "Q"	20.
[redacted]		[redacted] *C/P MOVE	M	001 MNFNA		
	REQD			002 05		
				003 MS03		
[redacted]		[redacted] I & I PIN O.D.		001 MNFGW		
	REQD	LARGE END 1.436/1.437		002 04		
		WEAR 1.434		003 EI01		
		SMALL END 1.373/1.374				
		WEAR 1.371				
		*C/P MOVE				
26 ✓	024	VAPOR DEGREASE *C/P MOVE		001 MNFDG		
				002 03		
				003 DG01		
26 ✓	026	STRIP CAD *C/P MOVE		001 MNFRC		
				002 02		
				003 CS01		
26 ✓	028	STRIP RUST *C/P MOVE		001 MNFRC		
				002 02		
				003 CS02		
26 ✓	030	STRIP CHROME		001 MNFRC		
		*C/P MOVE		002 02		
				003 SC02		
5 ✓	050	FIRST GRIND LARGE O.D. 1.421 MIN		001 MNFGE		
		*C/P MOVE		002 01		
				003 GE00		
6 ✓	[redacted]			001 MNFRB		
		*C/P MOVE		002 01		
				003 GE00		
[redacted]			M	001 MNFNA		
				002 06		
		DATE OUT_____ TIME OUT_____		003 TE03		
		(CONTINUED)				

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36019N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-166

36019N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041 | PAGE 4 OF 4 PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN	
	JURY BRACE APEX PIN	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *			
~~ZOZ~~ ✓	~~070~~	~~BAKE AMKS AT 350-400F WITHIN 8 HRS O~~ ETCH DATE IN_____TIME IN_____		~~001 MNPNG~~ 002 02 003 3K01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
[redacted]		*C/P MOVE * * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *	M	~~001 MNPNA~~ 002 06 003 ML04	
~~26~~ ✓	~~080~~	~~VAPOR DEGREASE~~ *C/P MOVE		~~001 MNPRC~~ 002 03 003 DG01	
~~26~~ ✓	~~090~~	~~PREPARE T.B. FOR~~ .008/.012 A2 100% COVERAGE *C/P MOVE		~~001 MNPRC~~ 002 01 003 SP02	
~~26~~ ✓	~~093~~	~~PREPARE O.D. FOR CHROME PLATE, MASK/~~ FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED_____		~~001 MNPRC~~ 002 02 003 BE01	
~~26~~ ✓	~~097~~	~~PREPARE O.D. FOR CHROME PLATE, GRIT~~ BLAST. *C/P MOVE		~~001 MNPRC~~ 002 01 003 BL04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36019N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-240

36019N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 39041 | 5 PAGE ___ OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	JURY BRACE APEX PIN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
20	100	~~CHROME PLATE LARGE O.D.~~		~~001 MN~~	
✓		SUFFICIENT TO GRIND TO 1.437		002 02	
				003 CP01	
		DATE OUT _____ TIME OUT _____		009 C0010	
		~~MECHANIC SIGN OFF REQUIRED~~			
		*C/P MOVE			
20	105	~~CHROME PLATE SMALL O.D.~~		~~001 MN~~	
✓		SUFFICIENT TO GRIND TO 1.374		002 02	
				003 CP01	
		DATE OUT _____ TIME OUT _____		009 C0020	
		~~MECHANIC SIGN OFF REQUIRED~~			
		*C/P MOVE			
~~20~~	110	~~BAKE 4HRS AT 350-400F WITHIN 4HRS OF~~		~~001 MN~~	
✓		CHROME		002 02	
		DATE IN _____ TIME IN _____		003 BK01	
		DATE OUT _____ TIME OUT _____			
		*C/P MOVE			
~~20~~	120	~~FINISH GRIND O.D.~~		~~001 MN FB~~	
✓		LARGE O.D. 1.436/1.437		002 01	
		*C/P MOVE		003 GE00	
~~20~~	125	~~FINISH GRIND O.D.~~		~~001 MN FB~~	
✓		SMALL O.D. 1.373/1.374		002 01	
		*C/P MOVE		003 GE00	
~~20~~	130	~~BAKE 4HRS AT 350-400F~~		~~001 MN RC~~	
✓				002 02	
		DATE IN _____ TIME IN _____		003 BK01	
		DATE OUT _____ TIME OUT _____			
		*C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36019N
		B	D	

AFLC FORM 955 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-165

36019N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041 | PAGE 6 OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	JURY BRACE APEX PIN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		*C/P MOVE	M	002 06	
		* * * * * * * * N O T E * * * * * * * *		003 ML04	
		IF LAST NDI OPERATION IS COMPLETED*			
		HERE, TAKE PRODUCTION COUNT. *			
		* * * * * * * * * * * * * * * * * *			
25	140	VAPOR DESMEAR *C/P MOVE		001 MNPRC	
✓				002 03	
				003 DG01	
[redacted]				001 MNPNA	
		*C/P MOVE	M	002 06	
		* * * * * * * * N O T E * * * * * * * *		003 ZS01	
		IF LAST NDI OPERATION IS COMPLETED*			
		HERE, TAKE PRODUCTION COUNT. *			
		* * * * * * * * * * * * * * * * * *			
25	140	PRIOR TO CAD/VAC CAD/IVD, GRIT BLAST		001 MNPRC	
✓		ALL AREAS TO BE CAD/VAC CAD/IVD		002 01	
		PLATED. *C/P MOVE		003 BL04	
25	140	VAC CAD		001 MNPRC	
✓		*C/P MOVE		002 02	
				003 VC01	
25	140	CAD PLATE IN SOLUTION		001 MNPRC	
✓		.OV SQ ST AT 4.5 - 6.3 AMPS		002 03	
				003 CA01	
		DATE OUT_____TIME OUT_____			
		*C/P MOVE			
261	170	BAKE 23HRS AT 250-400F WITHIN 4HRS		001 MNPRC	
✓		OF CAD PLATE		002 02	
		DATE IN_____TIME IN_____		003 BK01	
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36019N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE 1980—640-160

36019N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89041 | PAGE 7 OF 7 PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10. MODEL/DESIGN SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	JURY BRACE APEX PIN

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		DATE OUT_____ TIME OUT_____			
		*C/P MOVE			
26	170	~~CHROMATE CONVERSION FOR TYPE II CAD~~		~~001 MNPRC~~	
		*C/P MOVE		002 02	
				003 IR01	
[redacted]				~~001 MNPNA~~	
		*C/P MOVE	M	002 06	
	165	* * * * * * * N O T E * * * * * * *		003 ML04	
		IF LAST NDI OPERATION IS COMPLETED*			
		~~HERE, TAKE PRODUCTION COUNT.~~ *			
		* * * * * * * * * * * * * * * * * *			
26	180	~~VAC IVD ALUM PLATE CLASS 2 TYPE II~~		~~001 MNPRC~~	
		NOTE: OPERATION 170 MUST BE		002 03	
		ACCOMPLISHED IF PRIOR PLATING REWORK		003 IV01	
		IS DONE, BEFORE USING IVD OPTION.			
26	187	~~ALODINE IVD ALUM PLATE CLASS 1A~~		~~001 MNPRC~~	
		*C/P MOVE		002 03	
				003 TA01	
[redacted]	190	~~FINAL ACCEPTANCE OF WORK CONTROL~~		~~001 MNPQA~~	
		DOCUMENT FOR COMPLETENESS & ACCURACY		002 06	
	REQD	OF ALL PRECEDING OPERATIONS THIS OP		003 SA05	
[redacted]	200	~~FINAL PRODUCT VISUAL INSPECTION~~		~~001 MNPQA~~	
		*C/P MOVE		002 06	
	REQD			003 SA03	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				36019N

36020N **WORK CONTROL DOCUMENT (MEDS)** 1) DATE 8[illegible] PAGE 1 OF [illegible] PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC MNPGP	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.
	4A4-22-4 4S-1-182	

10 MODEL/DESIGN/SERIES	11 STOCK NUMBER	12 OPTIONAL
F-15 MAIN		

13. SERIAL NUMBER	14 NOUN
	SPRING

26378A

15. DISPATCH STATION P/N	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED NOMENCLATURE	P/N	U/A	18. MECHANIC	19. "P"	20. "Q"
68A410	725-1001	[illegible]	26338A	L / H			
			26338A	L / H			
68A410	725-1002	1620001323209	26337A	R / H			
			26337A	R / H			
		GOVERNING DIRECTIVES		AFLCR 66-51			
				MANOI 66-3			
		BLAST	IAW	MIL-STD-1504			
		CAD PLATE	IAW	MIL-STD-870			
		~~VAC CAD PLATE~~	~~IAW~~	~~MIL-C-8607~~			
		FMPI	IAW	MIL-STD-1949			
				P/O N01561			
		IVD ALUM PLATE	IAW	MIL-C-83488A			
		~~ALODINE~~	~~IAW~~	~~MIL-C-5541~~			
		*****UNIT COST		$26.14**********			
		********** S T E E L **********					
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 9 OF THIS WORK CARD. ALL APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.					
		"WARNING" MANY OF THE FOLLOWING REPAIR (CONTINUED)					

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				36020N
		B	D	

AFLC FORM 950 NOV. 80 PREVIOUS EDITION WILL BE USED

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★ U.S. GOVERNMENT PRINTING OFFICE 1980—640-266

[redacted] CONTROL DOCUMENT (MEDS) | 1. DATE 89041 | 2 PAGE ___ OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	SPRING

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PROCEDURE: REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	68A410725-1001 68A410725-1002			
	REQD	[redacted] DISASSEMBLE *C/P MOVE		001 MNFGW 002 02 003 LG02 005 x8745199	
	REQD	[redacted] DECREASE ONLY *C/P MOVE		001 MNFGW 002 02 003 DG02	
	REQD	[redacted] BLAST CLEAN ONLY (NOTE: PROTECT BUSHINGS) *C/P MOVE		001 MNFGW 002 03 003 BL07	
	REQD	[redacted] *C/P MOVE*		001 MNFGW 002 05 003 MS03	
	REQD	[redacted] INSPECT VISUALLY FOR DISTORTION ROUTE 100% FOR SPRING TEST, CAD/IVD ALUM PLATE *C/P MOVE		001 MNFGW 002 04 003 EI01	
	REQD	[redacted] TEST DOWN LOCK SPRING FOR LOAD AND DEFLECTION AND SERIALIZE PER DWG# 68A410725 (CONTINUED)		001 MNFGW 002 04 003 EI01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36020N
		B	D	

AFLC FORM 956 NOV. 80 — PREVIOUS EDITION WILL BE USED

[redacted] WORK CONTROL DOCUMENT - MED [redacted]

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMP

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	SPRING

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		HIGH READING LOW READING *C/P MOVE*			
27	040	REMOVE BUSHINGS *C/P MOVE*		001 MNFRA 002 03 003 BE01	
25 ✓	050	VAPOR DEGREASE *C/P MOVE		001 MNFRC 002 03 003 DG01	
25 ✓	060	STRIP VAC CAD *C/P MOVE		001 MNFRC 002 02 003 CS01	
25 ✓	070	STRIP RUST *C/P MOVE		001 MNFRC 002 02 003 CS02	
25 ✓	080	PRIOR TO VAC VAD/IVD, GRIT BLAST ALL AREAS TO BE VAC CAD/IVD PLATED. *C/P MOVE		001 MNFRC 002 01 003 BL04	
25 ✓	090	VAC CAD PLATE SPRING COMPLETE *C/P MOVE		001 MNFRC 002 02 003 VC01	
25 ✓	100	HOT WATER RINSE VAC CAD *C/P MOVE		001 MNFRC 002 02 003 IR01	
25 ✓	110	VAC I.V.D. ALUM PLATE CLASS 2 TYPE II *C/P MOVE		001 MNFRC 002 03 003 IV01	
25 ✓	120	ALODINE IVD ALUM PLATE CLASS 1A *C/P MOVE		001 MNFRC 002 03 003 TA01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36020N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-160

36020N **WORK CONTROL DOCUMENT (MEDS)** | 1. DATE 89041 | PAGE 4 OF 4 PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	SPRING

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
[redacted]		* * * N O T E * * * * * * *	M	002 06	
	?	IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *		003 ML14	
		* * * * * * * * * * * * * * *			
		*C/P MOVE			
	140	~~INSTALL BUSHING IN PROPER LOC HOLES~~		00 [illegible]	
		"NOTE" DO NOT REAM		002 08	
		*C/P MOVE		003 8E01	
		*C/P MOVE			
		~~P/N M81934/1-03C-016~~			
		P/N M81934/1-07C-018			
[redacted]	150	~~FINAL ACCEPTANCE OF WORK CONTROL~~		001 MA [illegible]	
		DOCUMENT FOR COMPLETENESS & ACCURACY		002 06	
	REQD	OF ALL PRECEDING OPERATIONS THIS 958		003 SA03	
		*C/P MOVE			
[redacted]	160	~~FINAL PRODUCT VISUAL INSPECTION~~		001 MA [illegible]	
		*C/P MOVE		002 06	
	REQD			003 SA03	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				36020N
		B	D	

3.20

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1981—340-865

36022N

89041

1

WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE 1 OF 1 PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCING RCC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4A4-22-3 48-1-182	

10. MODEL, SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 BOMLAR TRUNNION

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
68A410638-1009		LH 1620010753563 36309A L / H			
[redacted]					
68A410638-1010		RH 1620010753564 36319A R / H			
68A410638-1010		RH 1620010753564 36337A R / H			

GOVERNING DIRECTIVES: AFLCR 66-51
MANDI 66-3

BLAST IAW MIL-STD-1504
FMPI IAW MIL-STD-1949
P/O N0561

CAD IAW MIL-STD-870
BAKE IAW 48-1-182
MANDI 74-12
&/OR P/O N61891

IVD ALUM PLATE IAW MIL-C-83488A
ALODINE IAW MIL-C-5541

**********S T E E L**********
*********250-300 KSI 300 M**********
*********UNIT COST $983.65 **********

ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.

*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.

**********"W A R N I N G"**********
(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36022N
		B	D	

AFLC FORM 358 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980—311-966

36022N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041 | PAGE 2 OF ___ PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 COLLAR TRUNNION

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
	001	68410638-1009 68A410638-1010			
34D	005	DISASSEMBLE *C/P MOVE		001 MNPGW	
	REQD			002 02 003 LG02 005 X8745199	
34C	007	CHEM CLEAN *C/P MOVE		001 MNPGW	
	REQD			002 03 003 SL01	
34B	009	BLAST CLEAN ONLY *C/P MOVE		001 MNPGW	
	REQD			002 03 003 BL07	
34B	011	BAKE 4 HRS @ 350-400F		001 MNPGW	
	REQD	DATE & TIME IN_____ DATE & TIME OUT_____ *C/P MOVE		002 03 003 BK03	
34M	013	F.M.P.I. *C/P MOVE		001 MNPNA	
	REQD		M	002 03 003 MB03	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENTATION 36022N
		B	D	

* U.S. GOVERNMENT PRINTING OFFICE: 1985-461-003

AFLC FORM 988 NOV. 80 PREVIOUS EDITION WILL BE USED

36022N

WORK CONTROL DOCUMENT (MEDS)

1. DATE 89041 | PAGE 3 OF PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 COLLAR TRUNNION

15. DISPATCH STATION	16. PERF RCC/OP (MED)	17.	18. MECHANIC	19.	20.
		E AND I FLANGE BUSHING 0.375/0.379		001 MNPGW	
		BUNGEE ATTACH BOSS .500/.5015		002 04	
	REQD	CYLINDER ATTACH BOSS 2.742/2.744		003 EI01	
		C/P MOVE			
		* * * * * * * N O T E * * * * * * *			
		ROUTE UPPER COLLAR HALF AND LOWER *			
		COLLAR HALF AS MATCHED SET *			
		* * * * * * * * * * * * * * * * * *			
26	030	VAPOR DEGREASE *C/P MOVE		001 MNPRC	
				002 03	
				003 DG01	
26	040	STRIP CAD *C/P MOVE*		001 MNPRC	
				002 03	
				003 CS01	
26	050	STRIP RUST *C/P MOVE*		001 MNPRC	
				002 02	
				003 CS02	
69	070	O/S BUNGEE ATTACH BOSS NOT TO EXCEED		001 MNPRA	
		0.5651 *C/P MOVE*		002 03	
				003 BE01	
69	080	O/S FLANGE BUSHING BOSS NOT TO		001 MNPRA	
		EXCEED 0.5651 *C/P MOVE*		002 03	
				003 BE01	
69	090	MODIFY LIGHT WEIGHT COLLARS INTO		001 MNPRA	
		HEAVYWEIGHT IAW DRWG 68A410638		002 03	
		*C/P MOVE		003 LE02	
				005 X8633621	
69	095	REIDENTIFY COLLARS AFTER MOD.		001 MNPRA	
		R/H - 68A410638-2020		002 03	
		L/H - 68A410638-2019		003 BE01	
		*C/P MOVE			
26	110	TEMPER ETCH REWORKED AREAS		001 MNPNA	
		TIME OUT_____DATE OUT_____		002 06	
		C/P MOVE		003 TE03	
		(CONTINUED)			

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/ID 36022N

PREVIOUS EDITION WILL BE USED

36022N

WORK CONTROL DOCUMENT (MEDS)

1. DATE 89041 | PAGE 1 OF 4 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. COLLAR TRUNNION

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. * * * * * WORK TO BE ACCOMPLISHED * * * * *	18. MECHANIC	19. "P"	20. "Q"
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *			
26B	120	BAKE 4 HRS WITHIN 8 HRS OF ETCH		001 MNPRC	
		DATE AND TIME IN_____		002 02	
		DATE AND TIME OUT_____ *C/P MOVE*		003 BK01	
8A	130	F.M.P.I *C/P MOVE*		001 MNPNA	
		* * * * * * * N O T E * * * * * * *		002 02	
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *		003 ML04	
26	140	VAPOR DEGREASE *C/P MOVE*		001 MNPRC	
				002 03	
				003 DG01	
26	150	SHOTPEEN COLLAR I.D. .012 A2 100%		001 MNPRC	
		COVERAGE *C/P MOVE*		002 01	
				003 SP02	
26	160	SHOTPEEN REWORKED AREAS .012 A2		001 MNPRC	
		100% COVERAGE *C/P MOVE*		002 01	
				003 SP02	
26	260	GRIT BLAST ALL AREAS TO BE CAD/IVD		001 MNPRC	
		*C/P MOVE		002 01	
				003 BL04	
26	270	CAD PLATE E II CLASS II		001 MNPRC	
		TIME OUT_____ DATE OUT_____		002 03	
		C/P MOVE		003 CA01	
26B	280	BAKE 23 HRS WITHIN 4 HRS OF CAD		001 MNPRC	
		DATE & TIME IN_____		002 02	
		DATE & TIME OUT_____		003 BK01	
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36022N
		B	D	

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AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980-340-855

36022N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041 | PAGE 5 OF ___ PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES	11 STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14 MODULAR TRUNNION	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		*C/P MOV			
26	290	IRIDITE *C/P MOVE*		001 MNPRC	
				002 02	
				003 IR01	
26	330	VAC, IVD ALUM PLATE CLASS 2 TYPE II		001 MNPRC	
		NOTE: OPERATION 140 MUST BE		002 03	
		ACCOMPLISHED IF PRIOR PLATING REWORK		003 IV01	
		IS DONE, BEFORE USING IVD OPTION.			
		*C/P MOVE			
26	340	ALODINE IVD ALUM PLATE CLASS 1A		001 MNPRC	
		C/P MOVE		002 03	
				003 TA01	
69	350	MACHINE BUNGEE ATTACH BUSHING		001 MNPRA	
		C/P MOVE		002 03	
		P/N 7829423-33		003 LE02	
69	360	INSTALL BUSHING IN BUNGEE ATTACH		001 MNPRA	
		BOSS REAM TO .500/.5015 *C/P MOVE*		002 03	
		P/N 7829423-33 (1) EA		003 BE01	
69	370	MACHINE FLANGED BUSHING		001 MNPRA	
		C/P MOVE		002 03	
		P/N ST4M139C6-23		003 LE02	
		P/N 782924-93			
69	380	INSTALL FLANGED BUSHING REAM .375/		001 MNPRA	
		.376 *C/P MOVE*		002 03	
		P/N ST4M139C6-23 (1) EA		003 BE01	
34A	400	FINAL ACCEPTANCE OF WORK CONTROL		001 MNPGW	
		DOCUMENT OF COMPLETENESS & ACCURACY		002 04	
	REQD	OF ALL PRECEDING OPERATIONS THIS 958		003 ML01	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN 36022N
		B	D	

PREVIOUS EDITION WILL BE USED

36022N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041 | PAGE 6 OF 6 PAGES

2. JOB ORDER NO.	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOMLAR TRUNNION	

15. DISPATCH STATION	16. PERF RCC/OP	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19.	20.
	4N60	FINAL PRODUCT VISUAL INSPECTION		001 MNPGW	
		C/P MOVE		002 06	
	REQD			003 ML01	
34A	420	ASSEMBLE *C/P MOVE*		001 MNPGP	
				002 03	
				003 SA03	
34P	430	PAINT		001 MNPGP	
		1. CLEAN		002 09	
		2. MASK		003 SP03	
		3. PRIME			
		4. PAINT 1ST COAT			
		5. PAINT 2ND COAT *C/P MOVE			
34P	440	FINAL ACCEPTANCE OF WORK CONTROL		001 MNPGP	
		DOCUMENT FOR COMPLETNESS & ACCURACY		002 09	
	REQD	OF ALL PRECEDING OPERATIONS THIS 958		003 SP03	
34P	450	FINAL PRODUCT VISUAL INSPECTION		001 MNPGP	
		C/P MOVE		002 09	
	REQD			003 SP03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36022N
		B	D	

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36023N **WORK CONTROL DOCUMENT (MEDS)** | 1 DATE 89072 | PAGE 1 OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC MNPGP	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.
	4A4-22-3 48-1-182	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
F-15 MAIN		

13. SERIAL NUMBER	14 NOUN
	CONNECTING LINK ASSY

26378A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
68A410	11-1001	NSN [redacted] P/N 26338A L / H 26337A R / H			
		~~GOVERNING DIRECTIVES: AFLCR 66-51~~ MANDI 66-3 ALAST IAW MIL-STD-1504 MAGNETIC IAW MIL-STD-1516			
		UNIT COST $ 233.23 *** **********T I T A N I U M*******			
		~~ALL PERSONNEL INVOLVED IN THE WORK~~ PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 6 OF THIS AFLC FORM 958. THE APPLICABLE T.O. AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P ABOVE) FOR MOVED BETWEEN OPERATIONS/DISPATCH STATIONS.			
		~~WARNING~~ MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS ~~WHICH ARE POTENTIALLY DANGEROUS TO~~ PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36023N
		B	D	

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WORK CONTROL DOCUMENT (MEDS)

1 DATE 89072 | 2 PAGE__OF__PAGES

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10 MODEL,DESIGN,SERIES	11 STOCK NUMBER	12 *OPTIONAL

13. SERIAL NUMBER	14 NOUN
	CONNECTING LINK ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		START.			
	001	65A41061I 1001			
[redacted]		INSPECTABLE *C/P MOVE		001 MNUSW	
	REQD			002 02	
				003 LG02	
				005 X8745199	
[redacted]		CHEM CLEAN *C/P MOVE		001 MNUSW	
	REQD			002 03	
				003 AC02	
[redacted]		BLAST CLEAN ONLY *C/P MOVE		001 MNUSW	
	REQD			002 03	
				003 BL07	
[redacted]		*C/P MOVE		001 MNUSW	
			M	002 05	
	REQD			003 ZY05	
[redacted]		& I INSPECTION (AS PER FIG 2-5)		001 MNUSW	
	REQD	BUSHING #23 .425/.428		002 04	
		BUSHING #24 .325/.328		003 EI01	
		SPHERICAL BEARING I.D. .3745/.3770			
		CHECK BEARING FOR EXCESSIVE PLAY OR LOOSENESS BETWEEN RACE AND LINK			
		*C/P MOVE			
[redacted]		[redacted]		001 MNUSW	
		STAKE METALLIZE [redacted] PER T.O.		002 03	
		*C/P MOVE		003 BE01	
[redacted]		[redacted]		001 MNUSW	
		STAKE AS PER T.O.		002 03	
		C/P MOVE		003 BE01	
		(CONTINUED)			

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				36023N
		B	D	

AFLC FORM 988 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1981—840-[illegible]

36023N **WORK CONTROL DOCUMENT (MEDS)** 1 DATE 89022 PAGE 3 OF 3 PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEG/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	CONNECTING LINK ASSY

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		P/N [illegible]			
	039	MACHINE BUSHING *C/P MOVE P/N 68A410777-2001		001 MNTRA 002 03 003 LE02	
	060	INSTALL BUSHING P/N 68A410777-2001 MACHINE I.D. .425/.426 *C/P MOVE		001 MNTRA 002 03 003 BE01	
	064	MACHINE BUSHING *C/P MOVE P/N 68A410777-2003		001 MNTRA 002 03 003 LE02	
	065	INSTALL BUSHING P/N 68A410777-2003 MACHING I.D. .3257/.326		001 MNTRA 002 03 003 BE01	
	REQD	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 M-I-SP 002 06 003 SA03	
	REQD	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 [illegible] 002 06 003 SA03	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN 36023N
		B	D	

AI LC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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36025N

WORK CONTROL DOCUMENT (MEDS)

1. DATE 89C41 | PAGE 1 OF 1 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4A4-22-3 4S-1-182	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
F-15 MAIN		

13. SERIAL NUMBER	14. NOUN
	BELL CRANK ASSEMBLY

263384

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/M: 68A41	0601-1001	N.S.L. N/N 26338A L / H S/N 26337A R / H			
		~~GOVERNING DIRECTIVES:~~ AFLCR 66-51 MANDI 66-3			
		BLAST IAW MIL-STD-1504 FPI IAW MIL-STD-6866			
		********** **********T I T A N I U M********** **********			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE ~~FAMILIAR WITH ALL PERTINENT SAFETY~~ PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF ~~THIS AFLC FORM 958~~. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		~~MACHINED~~ PARTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		W A R N I N G MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF ~~EQUIPMENT, PROCESSES & CHEMICALS~~ WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO ~~PRECLUDE INJURIES.~~			
		REQD (MANDATORY REQUIREMENT) IN (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36025N
		B	D	

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-100

[redacted] CONTROL DOCUMENT (MCD) [redacted] 9041 PAGE [redacted] OF [redacted] PAGES

1. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
1				

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	**14. NOUN**	
	BELL CRANK ASSEMBLY	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	68A415201-1001			
[redacted]		DISASSEMBLE *C/P MOVE		001 MNFGW 002 02 003 LG02	
[redacted]	*REQD*			005 X8745199	
[redacted]		DEGREASE ONLY *C/P MOVE		001 MNFGW 002 02 003 DG02	
[redacted]	*REQD*				
[redacted]		BLAST CLEAN ONLY *C/P MOVE		001 MNFGW 002 03 003 BL07	
[redacted]	*REQD*				
[redacted]		*C/P MOVE		001 MNFNA 002 05 003 ZY05	
[redacted]	*REQD*				
[redacted]		N & I INSPECTION (AS PER FIG 6-2, REF #18 & 19.		001 MNFGW 002 04	
	REQD	LINK HOLE -.5000 +.0015 -.0000 CYLINDER HOLE 1.496 +.0010 -.0000 PIN 2ND HOLE .4375 +.0020 -.0000 BUSHING I.D. 1.4367/1.4372/1.4390 *C/P MOVE		003 EI01	
[redacted]		[redacted] HOLE TO 1.5597/1.560 *C/P MOVE		001 MNFRA 002 03 003 BE01	
[redacted]		*C/P MOVE P/N 7829424-61		001 MNFRA 002 03 003 LE02	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN 36025N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/ACC	5 DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8 TECH DATA	9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES	11 STOCK NUMBER	12 OPTIONAL

13. SERIAL NUMBER	14 NOUN
	BELL CRANK ASSEMBLY

15. DISPATCH STATION	16. PERF RCC/OP NO.	17.	18. MECHANIC	19. "P"	20. "O"
07	040	INSTALL OVERSIZE [redacted] P/N 7829424-61, [redacted] 1.496/1.497 64 RMS FINISH PRESS FIT -.0010/.0030 *C/P MOVE		001 MNFRA 002 03 003 HH00	
[redacted]	049	DRILL .#10 DIA THRU 2 HOLES IN LINE *C/P MOVE		001 MNFRA 002 03 003 DP02	
07	050	AFTER CYL PUSHING FACES PLACE REAM/ MACHINE HOLE [redacted] D .4375 +.0020 0.0000 *C/P MOVE		001 MNFRA 002 03 003 BE01	
07	060	MACHINE [redacted] TO .5630 .5647 *C/P MOVE		001 MNFRA 002 03 003 BE01	
07	069	MACHINE O/S [redacted] *C/P MOVE P/N7829418-03		001 MNFRA 002 03 003 LE02	
07	070	INSTALL OVERSIZE [redacted] MOVING P/N 7829418-03 [redacted] TO .5600/ .5015 64 RMS FINISH PRESS FIT -.0010/.0030 *C/P MOVE		001 MNFRA 002 03 003 BE01	
[redacted]	120 *REQD*	FINAL MODIFICATION OF WORK CONTROL DOCUMENT FOR COMPLETENESS AND ACCURACY OF ALL PRECEDING OPERATIONS THIS 950		001 MNSP 002 03 003 SA03	
[redacted]	970 *REQD*	FINAL PRODUCT VISUAL IN [redacted] *C/P MOVE		001 [illegible] 002 03 003 SA03	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				36025N
		B	D	

AVLC FORM 662 NOV 80

36026N

WORK CONTROL DOCUMENT (MEDS)

1. DATE 89041 | PAGE 1 OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
		MNPGP		

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
	4A4-22-3-4 4S-1-182	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
F-15 MAIN LANDI NG GEAR		

13. SERIAL NUMBER	14. NOUN
	HIGH PRESSURE PISTON

26337A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 68A410	90-2001	[redacted] 6337A 26338A			
		**********UNIT COST $783.00**********			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3			
		BLAST IAW MIL-STD-150			
		BAKE IAW 4S-1-182 MAOI 74-12			
		FPI IAW MIL-STD-6866			
		FMPI IAW MIL-STD-1949			
		P/O N01561			
		CAD PLATE IAW MIL-STD 870			
		STRIP IAW MIL-STD-871			
		TEMPER ETCH IAW MIL-STD-867			
		SHOTPEEN IAW MIL S [illegible]			
		CHROME PLATE IAW MIL-STD-150			
		NICKEL PLATE IAW MIL-STD-868			
		IVD ALUM PLATE IAW MIL-C-83488A			
		ALODINE IAW MIL S 5541			
		**********STEEL 300M 280/300 KSI**********			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. [illegible]			
		ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		**********W A R N I N G**********			
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36026N
		B	D	

AFLC FORM 968 NOV. 80 — PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980-340-016

36026N

WORK CONTROL DOCUMENT (MEDS)

1. DATE 89041 | PAGE 2 OF PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	HIGH PRESSURE PISTON

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
	001	88410790 2001			
[redacted]		DISASSEMBLE *C/P MOVE		001 MNFGW 002 02 003 LG02	
	REQD			005 XB745199	
[redacted]		RELEASE ONLY *C/P MOVE		001 MNFGW 002 02	
	REQD			003 DG02	
[redacted]		BLAST CLEAN GLY *C/P MOVE		001 MNFGW 002 03	
	REQD			003 BL07	
[redacted]		HVE 1 HRS AT 350/400F		001 MNFGW 002 03	
	REQD	DATE IN _____ TIME IN _____		003 BK03	
		DATE _____ AT _____			
		*C/P MOVE			
[redacted]		*C/P MOVE		001 MNFNA	
	REQD		M	002 05 003 MS03	
[redacted]		V & I INSPECTION		001 MNFGW	
	REQD	PISTON LANDS O.D 4.9325/4.9345 WEAR 4.9285 (CONTINUED)		002 04 003 EX01	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				36026N
		B	D	

AFLC FORM 858 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1985—461-015

36026N

WORK CONTROL DOCUMENT (MEDS)

1. DATE 27041 | 3. PAGE __ OF __ PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION REC/RCC	5. DATE EARNED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	HIGH PRESSURE PISTON

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PISTON LANDS I.D. 3.0060/3.0020 WEAR 3.0060 GROOVE O.D 4.4575/4.4605 WEAR 4.4555 GROOVE I.D. 3.369/3.371 WEAR 3.373 *C/P MOVE			
20 ✓	024	VAPOR DEGREASE *C/P MOVE		001 MNTRC 002 03 003 ZI01	
20 ✓	026	STRIP CAD *C/P MOVE		001 MNTRC 002 02 003 CS01	
20 ✓	028	STRIP RUST *C/P MOVE		001 MNTRC 002 02 003 CS02	
20 ✓	030	STRIP CHROME PISTON LANDS O.D. *C/P MOVE		001 MNTRC 002 02 003 SS02	
20 ✓	040	STRIP CHROME PISTON LANDS I.D. *C/P MOVE		001 MNTRC 002 02 003 SS02	
20 ✓	042	STRIP CHROME PISTON I.D. *C/P MOVE		001 MNTRC 002 02 003 SL02	
20 ✓	050	STRIP NICKEL PISTON GROOVE O.D. *C/P MOVE		001 MNTRC 002 03 003 SN01	
20 ✓	060	STRIP NICKEL PISTON GROOVE I.D. *C/P MOVE		001 MNTRC 002 03 003 SN01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36026N
		B	D	

AFLC FORM 988 NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980-340-...

36026N **WORK CONTROL DOCUMENT (MEDS)**

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SERVICE	5. DATE SERIES	6. DATE [redacted]

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	HIGH PRESSURE PISTON

15. DISPATCH STATION	16. PERF RCC/OP NO	17.	18. MECHANIC	19. "P"	20. "Q"
8	070	FIRST GRIND [redacted]		001 MNFRE	
		MIN. DIA. 4.9125		002 02	
		*C/P MOVE		003 GE01	
8	080	FIRST GRIND PISTON [redacted]		001 MNFRE	
		MAX. DIA. 3.022		002 02	
		*C/P MOVE		003 GI03	
				005 X8745175	
8	090	FIRST GRIND PISTON [redacted]		001 MNFRE	
		MIN. DIA. 4.4395		002 02	
		*C/P MOVE		003 GE01	
8	100	FIRST GRIND PISTON [redacted]		001 MNFRE	
		MAX. DIA. 3.389		002 02	
		*C/P MOVE		003 GI03	
				005 X8745175	
[redacted]				001 MNFNA	
		TIME OUT _____ DATE OUT _____	M	002 06	
		*C/P MOVE		003 TE03	
		* * * * * * * * N O T E * * * * * * * * *			
		IF LAST NDI OPERATION IS COMPLETED*			
		HERE, TAKE PRODUCTION COUNT *			
		* * * * * * * * * * * * * * * * * * * *			
ASE	120	BAKE 4 HRS WITHIN 8 HRS OF ETCH		001 MNFRE	
✓				002 02	
		DATE IN _____ TIME IN _____		003 BK01	
		DATE OUT _____ TIME OUT _____			
		*C/P MOVE			
[redacted]					
		*C/P MOVE		001 MNFNA	
		* * * * * * * * N O T E * * * * * * * * *	M	002 06	
		IF LAST NDI OPERATION IS COMPLETED*		003 ML04	
		HERE, TAKE PRODUCTION COUNT *			
		* * * * * * * * * * * * * * * * * * * *			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36026N
		B	D	

AFLC FORM 9** NOV. 80 PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980—340-

36026N

WORK CONTROL DOCUMENT (MEDS)

1. JOB ORDER NO	2. QUANTITY	3. PRODUCTION SEC/RCC	4. DATE SCHED	5. DATE COMPLETED

6. PART NUMBER	7. TECH DATA	8. ITEM SERIAL NO.

9. MODEL-DESIGN-SERIES	10. STOCK NUMBER	11. OPTIONAL

12. SERIAL NUMBER	13. NOUN
	HIGH PRESSURE PISTON

14. DISPATCH STATION	15. PERF RCC/OP NO	16. WORK TO BE ACCOMPLISHED	17. MECHANIC	18. "P"	18. "O"
26 ✓	139	VAPOR DEGREASE *C/P MOVE		001 MNFRC 002 03 003 DG01	
26 ✓	140	SHOTPEEN REWORKED AREA'S INTENSITY OF .009/.012A *C/P MOVE		001 MNFRC 002 01 003 SP02	
26 ✓	145	PREPARE PISTON LANDS O.D. FOR CHROME PLATE CLASS III TYPE II MASK/FIXTURE/ETC MECHANIC SIGN OFF REQD_____		001 MNFRC 002 02 003 BE01 005 X8412386	
26 ✓	147	PREPARE PISTON LANDS O.D. FOR CHROME PLATE GRIT BLAST *C/P MOVE		001 MNFRC 002 01 003 BL04	
26 ✓	150	CHROME PLATE PISTON LANDS O.D. CLASS III TYPE II SUFF. TO GRIND TO 4.9325/4.9345		001 MNFRC 002 02 003 CP01 005 X8412386	
		DATE OUT_____ TIME OUT_____ MACHANIC SIGN OFF REQD_____ *C/P MOVE		005 SC410	
26 ✓	155	BAKE 4 HRS AT 375° +25° -10° WITHIN 4 HRS OF CHROME DATE IN_____ TIME IN_____		001 MNFRC 002 02 003 BK01	
		DATE OUT_____ TIME OUT_____ *C/P MOVE			
26 ✓	157	PREPARE PISTON LANDS I.D. FOR CHROME PLATE CLASS III TYPE II MASK/FIXTURE ETC MECHANIC SIGN OFF REQD_____		001 MNFRC 002 02 003 BE01 005 X8412386	
26 ✓	158	PREPARE PISTON LANDS I.D. FOR CHROME PLATE, GRIT BLAST *C/P MOVE		001 MNFRC 002 01 003 BL04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36026N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE 1980—340-160

36026N

WORK CONTROL DOCUMENT (MED)

1. DATE 7041 | PAGE 4 OF PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	HIGH PRESSURE PISTON

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
20 ✓	160	CHROME PLATE PISTON LAND I.D. CLASS III TYPE II SUFF. TO GRIND TO 3.000/3.002 DATE OUT_____TIME OUT_____ MECHANIC SIGN OFF REQD_____ *C/P MOVE		001 002 02 003 CP01 005 X8412386	MNFRC "Q" GI410
20B ✓	170	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME DATE IN_____TIME IN_____ DATE OUT_____TIME OUT_____ *C/P MOVE		001 002 02 003 BK01	MNFRC
20 ✓	180	FINISH GRIND PISTON LAND O.D. 4.9325/4.9345 32RMS *C/P MOVE		001 002 02 003 GE01	MNFRC
20 ✓	190	FINISH GRIND PISTON LAND I.D. 3.000/3.002 32 RMS *C/P MOVE		001 002 02 003 GI03 005 X8745175	MNFRC
20B ✓	200	BAKE 4 HRS AT 350-400 F DATE IN_____TIME IN_____ BAKE 4HR		001 002 02 003 BK01	MNFRC
20B ✓	205	PREPARE PISTON GROOVE O.D. FOR NICKEL PLATE, MASK/FIXTURE/ETC *C/P MOVE		001 002 03 003 BE01 005 X8412386	MNFRC
20 ✓	207	PREPARE PISTON GROOVE O.D. FOR NICKEL PLATE, GRIT BLAST *C/P MOVE		001 002 01 003 BL04	MNFRC

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36026N
		B	D	

AFLC FORM 958 NOV. 80 — PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-000

36026N

WORK CONTROL DOCUMENT (MEDS)

1. DATE 89041 | PAGE 7 OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	HIGH PRESSURE PISTON

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
20 ✓	210	NICKEL PLATE PISTON GROOVE O.D. SUFF. TO GRIND TO 4.4575/4.4605 DATE OUT----------TIME OUT---------- *C/P MOVE		001 MNFRC 002 03 003 NP01 005 XB412386	
20 ✓	214	BAKE 24 HRS AT 350-400F WITHIN 4 HRS OF NICKEL PLATE DATE IN_____TIME IN_____ DATE OUT_____TIME OUT_____ *C/P MOVE		001 MNFRC 002 02 003 BK01	
20 ✓	212	PREPARE PISTON GROOVE I.D. FOR NICKEL PLATE, MASK/FIXTURE/ETC *C/P MOVE		001 MNFRC 002 03 003 BE01 005 XB412386	
20 ✓	213	PREPARE PISTON GROOVE I.D. FOR NICKEL PLATE, GRIT BLAST *C/P MOVE		001 MNFRC 002 01 003 BL04	
20 ✓	220	NICKEL PLATE PISTON GROOVE I.D. SUFF. TO GRIND TO 2.367/2.371 DATE OUT----------TIME OUT---------- *C/P MOVE		001 MNFRC 002 02 003 NP01 005 XB412386	
20H ✓	230	BAKE 24 HRS AT 350-400F WITHIN 4 HRS OF NICKEL PLATE DATE IN----------TIME IN---------- DATE OUT----------TIME OUT---------- *C/P MOVE		001 MNFRC 002 02 003 BK01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36026N
		B	D	

AFLC FORM 958 NOV. 80 — PREVIOUS EDITION WILL BE USED

* U.S. GOVERNMENT PRINTING OFFICE 1980-640-160

36026N

WORK CONTROL DOCUMENT (MEDS)

1. DATE 89041 | PAGE 8 OF ___ PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION REC/REQ	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL/DESIGN SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	HIGH PRESSURE PISTON

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
8	240	FINISH GRIND PISTON GROOVE O.D. 4.4575/4.4605 32 RMS *C/P MOVE		001 MNURB 002 02 003 GE01	
8	250	FINISH GRIND PISTON GROOVE I.D. 3.969/3.971 32 RMS *C/P MOVE		001 MNURB 002 02 003 GI03 005 AS745175	
2GP	255	BAKE 4 HRS AT 300-400 F DATE IN----------TIME IN---------- DATE OUT----------TIME OUT *C/P MOVE		001 MNURB 002 02 003 BK01	
[redacted]				001 MNURB	
		* * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	002 06 003 ML04	
25	265	VAPOR DEGREASE *C/P MOVE		001 MNURB 002 03 003 DS01	
[redacted]				001 MNURB	
		* * * * * * * N O T E * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	002 06 003 ZS01	
26	275	PRIOR TO CAD/IVD, GRIT BLAST ALL AREASE TO BE CAD/IVD PLATED *C/P MOVE		001 MNURB 002 01 003 BL04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36026N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—340-240

36026N

WORK CONTROL DOCUMENT (NEDS)

1. DATE 9041 — PAGE 1 OF 1 PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEQ/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	HIGH PRESSURE PISTON

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
20 ✓	280	~~CAD PLATE **ID ONLY~~ TYPE II CLASS I *C/P MOVE		001 MNPRC 002 03 003 CA01	
20B ✓	290	~~BAKE 23 HRS AT 350/400F WITHIN 4 HRS~~ OF CAD DATE IN_____TIME IN_____		~~001 MNPRC~~ 002 02 003 BK01	
		DATE OUT_____TIME OUT_____ *C/P MOVE			
20 ✓	295	~~INSPECT C/P MOVE~~		~~001 MNPRC~~ 002 02 003 IR01	
[redacted]				~~001 MNPNA~~	
	.65	* * * * * * * * N O T E * * * * * * * * IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	002 06 003 ML04	
20 ✓	305	~~VAC EVB ALUM PLATE ID ONLY CLASS 2~~ TYPE II NOTE: OPERATION--290 MUST BE ACCOMPLISHED IF PRIOR PLATING REWORK IS DONE, BEFORE ~~USAF E.V.E. (F-4N Aero Mod)~~		~~001 MNPRC~~ 002 03 003 IV01	
20 ✓	307	~~ALODINE 1VB ALUM PLATE CLASS 1A~~ *C/P MOVE		~~001 MNPRC~~ 002 03 003 TA01	
[redacted]	310	~~FINAL ACCEPTANCE OF WORK CONTROL~~ DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		~~001 MNPQR~~ 002 06 003 SA03	
	REQD				

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	36026N
		B	D	

AFLC FORM 958 NOV. 80 — PREVIOUS EDITION WILL BE USED

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* U.S. GOVERNMENT PRINTING OFFICE: 1980—640-165

36026N

WORK CONTROL DOCUMENT (MEDS)

2. JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL

13. SERIAL NUMBER	14. NOUN
	HIGH PRESSURE PISTON

15. [redacted]	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	320	FINAL PRODUCT VISUAL INSPECTION		001 MNF	QP
	REQD	*C/P.MOVE		002 06 003 SA03	

21. FINAL DESTINATION DISPATCH	FUNCTIONAL CODE	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A	C	23. DOCUMENT/SN
				36026N
		B	D	

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

★ U.S. GOVERNMENT PRINTING OFFICE: 1980-0-311-

[redacted] F-15 MG

LABOR STANDARDS OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 09/15/88 A-E046B-HM1-BY-H4S PAGE 0001
[redacted] RCC MMPRA 4A4-22-3 BAZZ4

SUB STEP	T E	M A	P K	SUPPLEMENT	DCC DC	ELEMENT	FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY	A PCT C
RA001	S	E	JA	01	1	K	00163	.41 PERCENT ENGR 89.2	F-15 MAIN OUTER CYLINDER	7.04		2.88		
0001		JA	01		00		.02		PART NUMBER/NSN	.000	.000	.000		0
0010								68A410702-1003	1620010667226					
0020								68A410702-1004	1620010667225					
0030								68A410702-1005	1620010760547					
0040								68A410702-1006	1620040753562					
0050								68A410702-1001	1620003592094					
0060								68A410702-1002	1620003486499					
0030		JA	01		15		.73		REMOVE BUSHING WITH PRESS	.089	.010	.075		1
0010	E				RBW	SU G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27525		.079		
0020	E				RLG	RS K1	1.00	REM BUSHING (1ST OR SINGLE)		.01099		.012		
0030	E				RJP	PW R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0040		JA	01		15		.05		NICK & BURR --40--	.351	.003	.020		0
0010	E				RBW	SU G1	.25	S/U FOR BENCH WORK GENERAL	PRORATED OVER 4 PARTS	.27525		.079		
0020	E				RLG	HP V7	1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078		
0030	E				RLG	HP V1	4.00	TURN OBJ 190$ IN STRAP VISE REPOSITION 4 TIMES		.00612		.028		
0040	E				GCL	CD A5130	.08	CLN SPT/SQ IN W/DRILL & BRSH65 SQ IN X 2 ROUGH & FINISH		.00138		.206		
0050	E				RJP	PW R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0045		JA	01		15		1.00		O/S HOLE ON MILL/SMALL PART	.911	.137	1.048		15
0010	E				KMH	SU V1	.25	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.145		
0020	E				RML	HP CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
0030	E				RML	AL AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E				RML	AL AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E				RML	BD CC	1.00	BORE HOLE 2 X 1 1/2 GROUP 4 USE PROPER ELEMENT/TABLE		.48656		.559		
0060	E				RJP	PW R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0050		JA	01		15		.05		OVERSIZE HOLE WITH REAMER	.353	.003	.020		0
0010	E				RBW	BU S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18469		.053		
0020	E				RLG	HP V7	1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078		
0030	E				RBW	BU R2	3.00	REAM WITH LEMPCO REAMER	3 PASSES	.07387		.253		
0040	E				RBW	DB A1	2.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.009		
0050	E				RJP	PW R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0070								OVERSIZE HOLE WITH REAMER						
0060		JA	01		15		.05		O/S HOLE ON MILL/SMALL PART	.760	.006	.044		1
0010	E				KMH	SU V1	.25	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.145		
0020	E				RML	HP CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
0030	E				RML	AL AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E				RML	AL AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E				RML	BD DA	1.00	BORE HOLE 2.5 X 1/2 GROUP 4 USE PROPER ELEMENT/TABLE		.33548		.385		
0060	E				RJP	PW R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0070		JA	01		15		.05		OVERSIZE HOLE WITH REAMER	.353	.003	.020		0
0010	E				RBW	BU G1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18469		.053		
0020	E				RLG	HP V7	1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078		
0030	E				RBW	BU R2	3.00	REAM WITH LEMPCO REAMER	3 PASSES	.07387		.253		
0040	E				RBW	DB A1	2.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.009		
0050	E				RJP	PW R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0080		JA	01		15		.05		OVERSIZE HOLE WITH REAMER	.353	.003	.020		0
0010	E				RBW	BU S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18469		.053		
0020	E				RLG	HP V7	1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078		
0030	E				RBW	BU R2	3.00	REAM WITH LEMPCO REAMER	3 PASSES	.07387		.253		

0040 E		RBW-DB-A1	2.00	DEBUR HOLE/CUTOUT BOTH SIDES			.00423		.009		
0050 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
	JA 01	15	.05		OVERSIZE HOLE WITH REAMER		.353	.003	.020		0
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18469		.053		
0020 E		RLG-HP-V7	1.00	OBJ IN/OUT STP VISE-HST HAND			.04831		.078		
0030 E		RBW-BU-R2	3.00	REAM WITH LEMPCO REAMER	3 PASSES		.07337		.253		
0040 E		RBW-DB-A1	2.00	DEBUR HOLE/CUTOUT BOTH SIDES			.00423		.009		
0060 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0095	JA 01	15	.05		OVERSIZE HOLE WITH REAMER		.353	.003	.020		0
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18469		.053		
0020 E		RLG-HP-V7	1.00	OBJ IN/OUT STP VISE-HST HAND			.04831		.078		
0030 E		RBW-BU-R2	3.00	REAM WITH LEMPCO REAMER	3 PASSES		.07337		.253		
0040 E		RBW-DB-A1	2.00	DEBUR HOLE/CUTOUT BOTH SIDES			.00423		.009		
0050 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0405	JA 01	15	1.00		HAND HONE BUSHING		.275	.041	.317		4
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18469		.053		
0020 E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING			.02062		.023		
0030 E		RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS		.27525		.079		
0040 N			1.00		HONE PART NAME		.10000		.115		
0060 E		RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT			.01603		.018		
0070 E		RBW-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D			.00333		.003		
0080 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0409	JA 01	15	.91		TURN BUSHING GROUP 1/BRONZE		.443	.060	.464		7
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143		
0020 E		RLA-HP-C1	4.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS		.01006		.046		
0030 E		KNL-TA-EC	4.00	DIA 1.50-2.00 REM .033-.250			.06699		.308		
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0410	JA 01	15	.91		INST/REAM SET FLANGED BUSH		1.010	.138	1.057		15
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18469		.053		
0020 E		RBW-BU-B1	4.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH		.23835		1.096		
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0419	JA 01	15	.05		TURN BUSHING GROUP 1/BRONZE		.443	.003	.025		0
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143		
0020 E		RLA-HP-C1	4.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS		.01006		.046		
0030 E		KNL-TA-EC	4.00	DIA 1.50-2.00 REM .033-.250			.06699		.308		
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0420	JA 01	15	.05		INST/REAM SET FLANGED BUSH		1.010	.008	.058		1
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18469		.053		
0020 E		RBW-BU-B1	4.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH		.23835		1.096		
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0429	JA 01	15	.91		TURN BUSHING GROUP 1/BRONZE		.211	.029	.222		3
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143		
0020 E		RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.011		
0030 E		KNL-TA-CC	1.00	DIA .501-1.00 REM .033-.250			.06699		.077		
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0430	JA 01	15	.91		HAND HONE BUSHING		.275	.038	.288		4
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18469		.053		
0020 E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING			.02062		.023		
0030 E		RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS		.27525		.079		
0040 N			1.00		HONE PART NAME		.10000		.115		
0060 E		RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT			.01603		.018		
0070 E		RBW-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D			.00333		.003		
0080 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0439	JA 01	15	.05		TURN BUSHING GROUP 1/BRONZE		.211	.001	.012		0
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143		
0020 E		RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.011		

0030	E		KML-TA-CC	1.00	DIA .501-1.00 REM .033-.250			.06699		.077	
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
		JA 01	15	.05		HAND HONE BUSHING		.275	.002	.016	0
0010	E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053	
0020	E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING			.02062		.023	
0030	E		RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS		.27525		.079	
0040	N			1.00		HONE PART NAME		.10000		.115	
0060	E		RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT			.01603		.018	
0070	E		RBW-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D			.00333		.003	
0080	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0449		JA 01	15	.91		TURN BUSHING GROUP 1/BRONZE		.211	.029	.222	3
0010	E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143	
0020	E		RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.011	
0030	E		KML-TA-CC	1.00	DIA .501-1.00 REM .033-.250			.06699		.077	
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0450		JA 01	15	.91		HAND HONE BUSHING		.275	.038	.288	4
0010	E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053	
0020	E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING			.02062		.023	
0030	E		RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS		.27525		.079	
0040	N			1.00		HONE PART NAME		.10000		.115	
0060	E		RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT			.01603		.018	
0070	E		RBW-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D			.00333		.003	
0080	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0459		JA 01	15	.05		TURN BUSHING GROUP 1/BRONZE		.211	.002	.012	0
0010	E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143	
0020	E		RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.011	
0030	E		KML-TA-CC	1.00	DIA .501-1.00 REM .033-.250			.06699		.077	
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
		JA 01	15	.05		HAND HONE BUSHING		.275	.002	.016	0
0010	E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053	
0020	E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING			.02062		.023	
0030	E		RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS		.27525		.079	
0040	N			1.00		HONE PART NAME		.10000		.115	
0060	E		RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT			.01603		.018	
0070	E		RBW-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D			.00333		.003	
0080	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0469		JA 01	15	.82		TURN BUSHING GROUP 4/STEEL		.849	.104	.801	11
0010	E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143	
0020	E		RLA-HP-C1	6.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.069	
0030	E		KML-TD-CC	6.00	DIA .501-1.00 REM .033-.250			.10898		.751	
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0470		JA 01	15	.82		INST/REAM SET FLANGED BUSH		.771	.095	.728	10
0010	E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053	
0020	E		RBW-BU-B1	3.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH		.23835		.822	
0030	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0479		JA 01	15	.05		TURN BUSHING GROUP 4/STEEL		.849	.006	.049	1
0010	E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143	
0020	E		RLA-HP-C1	6.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.069	
0030	E		KML-TD-CC	6.00	DIA .501-1.00 REM .033-.250			.10898		.751	
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0480		JA 01	15	.05		INST/REAM SET FLANGED BUSH		.771	.006	.044	1
0010	E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053	
0020	E		RBW-BU-B1	3.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH		.23835		.822	
0030	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
		JA 01	15	.82		TURN BUSHING GROUP 1/BRONZE		.297	.037	.280	4
0010	E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143	

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   0020 E          RLA-HP-C1  2.00 1ST PART IN-OUT SCROLL CHUCK                          .01006          .023
   0030 E          KML-TA-FC  2.00 DIA 2.00-3.00 REM .033-.250                          .07104          .163
   40 E            RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                         .01001          .011
        JA 01   15             .82                          HAND HONE BUSHING        .399   .049     .377     5
   0010 E          RBW-BU-S1   .25 SET UP TO REBUSH BOSSES   PRORATE OVER 4 PARTS     .18669          .053
   0020 E          RBW-BU-A4  2.00 INSTALL ONE STRAIGHT BUSHING                         .02062          .047
   0030 E          RBW-SU-G1   .25 S/U FOR BENCH WORK GENERAL PRORATE FOUR PARTS        .27525          .079
   0040 N                     2.00                          HONE PART NAME           .10000          .230
   0060 E          RSG-JP-05  1.00 PREP HAND DRILL CHANGE 1 BIT                         .01603          .018
   0070 E          RBW-BU-P1  2.00 BUTTERFLY POLISH BUSHING I D                         .00333          .007
   0080 E          RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                         .01001          .011
0499       JA 01   15             .05                          TURN BUSHING GROUP 1/BRONZE .297  .002     .017     0
   0010 E          RLA-SU-S3   .25 SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS     .49962          .143
   0020 E          RLA-HP-C1  2.00 1ST PART IN-OUT SCROLL CHUCK                         .01006          .023
   0030 E          KML-TA-FC  2.00 DIA 2.00-3.00 REM .033-.250                          .07104          .163
   0040 E          RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                         .01001          .011
   0500                       XXXXXXXXXXXX
0500       JA 01   15            1.00                          HAND HONE BUSHING        .399   .060     .459     7
   0010 E          RBW-BU-S1   .25 SET UP TO REBUSH BOSSES   PRORATE OVER 4 PARTS     .18669          .053
   0020 E          RBW-BU-A4  2.00 INSTALL ONE STRAIGHT BUSHING                         .02062          .047
   0030 E          RBW-SU-G1   .25 S/U FOR BENCH WORK GENERAL PRORATE FOUR PARTS        .27525          .079
   0040 N                     2.00                          HONE PART NAME           .10000          .230
   0060 E          RSG-JP-05  1.00 PREP HAND DRILL CHANGE 1 BIT                         .01603          .018
   0070 E          RBW-BU-P1  2.00 BUTTERFLY POLISH BUSHING I D                         .00333          .007
   0080 E          RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                         .01001          .011
9000       JA 01   15             .01                          LABOR STANDARD HISTORY   .000   .000     .000     0
   0010                       07SEP83 REVIEW & CHG OCC. FACTORS              0.86
   0011                       14NOV84 2 YR REVIEW W/OCC CHANGE > OLD STD <  1.21
    ?16                       19MAR85 DOWN GRADED NOT MARKET BASKET
   ,900                        J.CALDWELL TECH MANEAA
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TO INTERROGATE LABOR STANDARDS, INPUT

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 RCC PRD MROP MR
<---X----X---->
1234567890123456  ELSE PUT IN END
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OPER SUB STEP	TECH D	S L	S K	E #R	JA A	EA C	1 DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT	C
	S	E	JA	EA	1		K	88183	.41	PERCENT ENGR 89.2	F-15 MAIN OUTER CYLINDER	6.98		2.86		
			JA	01		00			.00		PART NUMBER/NSN	.000	.000	.000		0
	0030									68A410702-1005	1620010760547					
	0040									68A410702-1006	1620040753562					
0030			JA	01		15			.73		REMOVE BUSHING WITH PRESS	.089	.010	.075		1
	0010	E				RBW-SU-G1			.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27525		.079		
	0020	E				RLG-RS-K1			1.00	REM BUSHING (1ST OR SINGLE)		.01099		.012		
	0030	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0040			JA	01		15			.05		NICK & BURR --40--	.351	.003	.020		0
	0010	E				RBW-SU-G1			.25	S/U FOR BENCH WORK GENERAL	PRORATED OVER 4 PARTS	.27525		.079		
	0020	E				RLG-HP-V7			1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078		
	0030	E				RLG-HP-V1			4.00	TURN OBJ)90$ IN STRAP VISE REPOSITION 4 TIMES		.00612		.028		
	0040	E				GCL-CD-A5			130.00	CLN SPT/SQ IN W/DRILL & BRSH65 SQ IN X 2 ROUGH & FINISH		.00138		.206		
	0050	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0045			JA	01		15			1.00		O/S HOLE ON MILL/SMALL PART	.911	.137	1.048		15
	0010	E				KNH-SU-V1			.25	S/U VERT MILL BORE SMAL FXTR	PRORATE OVER 4 PARTS	.50518		.145		
	0020	E				RML-HP-CA			1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
	0030	E				RML-AL-AB			1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
	0040	E				RML-AL-AC			1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
	0050	E				RML-DD-CC			1.00	BORE HOLE 2 X 1 1/2 GROUP 4	USE PROPER ELEMENT/TABLE	.48656		.559		
	0060	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0050			JA	01		15			.05		OVERSIZE HOLE WITH REAMER	.353	.003	.020		0
	0010	E				RBW-BU-S1			.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
	0020	E				RLG-HP-V7			1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078		
	0030	E				RBW-BU-R2			3.00	REAM WITH LEMPCO REAMER	3 PASSES	.07337		.253		
	0040	E				RBW-DB-A1			2.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.009		
	0050	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
	0070									OVERSIZE HOLE WITH REAMER						
0060			JA	01		15			.05		O/S HOLE ON MILL/SMALL PART	.760	.006	.044		1
	0010	E				KNH-SU-V1			.25	S/U VERT MILL BORE SMAL FXTR	PRORATE OVER 4 PARTS	.50518		.145		
	0020	E				RML-HP-CA			1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
	0030	E				RML-AL-AB			1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
	0040	E				RML-AL-AC			1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
	0050	E				RML-DB-DA			1.00	BORE HOLE 2.5 X 1/2 GROUP 4	USE PROPER ELEMENT/TABLE	.33548		.385		
	0060	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0070			JA	01		15			.05		OVERSIZE HOLE WITH REAMER	.353	.003	.020		0
	0010	E				RBW-BU-S1			.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
	0020	E				RLG-HP-V7			1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078		
	0030	E				RBW-BU-R2			3.00	REAM WITH LEMPCO REAMER	3 PASSES	.07337		.253		
	0040	E				RBW-DB-A1			2.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.009		
	0050	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0080			JA	01		15			.05		OVERSIZE HOLE WITH REAMER	.353	.003	.020		0
	0010	E				RBW-BU-S1			.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
	0020	E				RLG-HP-V7			1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078		
	0030	E				RBW-BU-R2			3.00	REAM WITH LEMPCO REAMER	3 PASSES	.07337		.253		
	0040	E				RBW-DB-A1			2.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.009		
	0050	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0090			JA	01		15			.05		OVERSIZE HOLE WITH REAMER	.353	.003	.020		0
	0010	E				RBW-BU-S1			.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
	0020	E				RLG-HP-V7			1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078		

0030 E		RBW-BU-R2	3.00	REAM W/ LEMPCO REAMER	3 PASSES		.07337		.253		
0040 E		RBW-DB-A1	2.00	DEBUR HOLE/CUTOUT BOTH SIDES			.00423		.009		
0050 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0095	JA 01	15	.05		OVERSIZE HOLE WITH REAMER		.353	.003	.020		0
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053		
020 E		RLB-HP-V7	1.00	ADJ IN/OUT STP VISE-HST HAND			.04831		.078		
030 E		RBW-BU-R2	3.00	REAM WITH LEMPCO REAMER	3 PASSES		.07337		.253		
0040 E		RBW-DB-A1	2.00	DEBUR HOLE/CUTOUT BOTH SIDES			.00423		.009		
0050 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0405	JA 01	15	1.00		HAND HONE BUSHING		.265	.040	.305		4
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053		
0020 E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING			.02062		.023		
0030 E		RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS		.27525		.079		
0040 M			1.00		HONE PART NAME		.10000		.115		
0060 E		RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT			.01603		.018		
0070 E		RBW-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D			.00333		.003		
0080 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0409	JA 01	15	.91		TURN BUSHING GROUP 1/BRONZE		.443	.060	.464		7
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143		
0020 E		RLA-HP-C1	4.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS		.01006		.046		
0030 E		KML-TA-EC	4.00	DIA 1.50-2.00 REM .033-.250			.06699		.308		
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0410	JA 01	15	.91		INST/REAM SET FLANGED BUSH		1.010	.138	1.057		15
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053		
0020 E		RBW-BU-B1	4.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH		.23835		1.096		
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0419	JA 01	15	.05		TURN BUSHING GROUP 1/BRONZE		.443	.003	.025		0
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143		
0020 E		RLA-HP-C1	4.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS		.01006		.046		
0030 E		KML-TA-EC	4.00	DIA 1.50-2.00 REM .033-.250			.06699		.308		
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
	JA 01	15	.05		INST/REAM SET FLANGED BUSH		1.010	.008	.058		1
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053		
0020 E		RBW-BU-B1	4.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH		.23835		1.096		
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0429	JA 01	15	.91		TURN BUSHING GROUP 1/BRONZE		.211	.029	.222		3
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143		
0020 E		RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.011		
0030 E		KML-TA-CC	1.00	DIA .501-1.00 REM .033-.250			.06699		.077		
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0430	JA 01	15	.91		HAND HONE BUSHING		.265	.036	.278		4
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053		
0020 E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING			.02062		.023		
0030 E		RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS		.27525		.079		
0040 M			1.00		HONE PART NAME		.10000		.115		
0060 E		RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT			.01603		.018		
0070 E		RBW-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D			.00333		.003		
0080 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0439	JA 01	15	.05		TURN BUSHING GROUP 1/BRONZE		.211	.002	.012		0
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143		
0020 E		RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK			.01006		.011		
0030 E		KML-TA-CC	1.00	DIA .501-1.00 REM .033-.250			.06699		.077		
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011		
0440	JA 01	15	.05		HAND HONE BUSHING		.265	.002	.015		0
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053		
0020 E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING			.02062		.023		

0030 E		RBW-SU-B1	.25 S/U FOR BENCH WORK GENERAL		PRORATE FOUR PARTS		.27525		.079		
0040 N			1.00		HONE PART NAME		.10000		.115		
0060 E		RSG-JP-05	1.00 PREP HAND DRILL CHANGE 1 BIT				.01603		.018		
0070 E		RBW-BU-P1	1.00 BUTTERFLY POLISH BUSHING I D				.00333		.003		
0080 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC				.01001		.011		
0	JA 01	15	.91		TURN BUSHING GROUP 1/BRONZE		.211	.029	.222		3
0 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS		.49962		.143		
0020 E		RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK				.01006		.011		
0030 E		KML-TA-CC	1.00 DIA .501-1.00 REM .033-.250				.06699		.077		
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC				.01001		.011		
0450	JA 01	15	.91		HAND HONE BUSHING		.265	.036	.278		4
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS		.18669		.053		
0020 E		RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING				.02062		.023		
0030 E		RBW-SU-B1	.25 S/U FOR BENCH WORK GENERAL		PRORATE FOUR PARTS		.27525		.079		
0040 N			1.00		HONE PART NAME		.10000		.115		
0060 E		RSG-JP-05	1.00 PREP HAND DRILL CHANGE 1 BIT				.01603		.018		
0070 E		RBW-BU-P1	1.00 BUTTERFLY POLISH BUSHING I D				.00333		.003		
0080 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC				.01001		.011		
0459	JA 01	15	.05		TURN BUSHING GROUP 1/BRONZE		.211	.002	.012		0
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS		.49962		.143		
0020 E		RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK				.01006		.011		
0030 E		KML-TA-CC	1.00 DIA .501-1.00 REM .033-.250				.06699		.077		
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC				.01001		.011		
0460	JA 01	15	.05		HAND HONE BUSHING		.265	.002	.015		0
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS		.18669		.053		
0020 E		RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING				.02062		.023		
0030 E		RBW-SU-B1	.25 S/U FOR BENCH WORK GENERAL		PRORATE FOUR PARTS		.27525		.079		
0040 N			1.00		HONE PART NAME		.10000		.115		
0060 E		RSG-JP-05	1.00 PREP HAND DRILL CHANGE 1 BIT				.01603		.018		
0070 E		RBW-BU-P1	1.00 BUTTERFLY POLISH BUSHING I D				.00333		.003		
0080 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC				.01001		.011		
	JA 01	15	.82		TURN BUSHING GROUP 4/STEEL		.849	.104	.801		11
010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS		.49962		.143		
0020 E		RLA-HP-C1	6.00 1ST PART IN-OUT SCROLL CHUCK				.01006		.069		
0030 E		KML-TD-CC	6.00 DIA .501-1.00 REM .033-.250				.10898		.751		
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC				.01001		.011		
0470	JA 01	15	.82		INST/REAM SET FLANGED BUSH		.771	.095	.728		10
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS		.18669		.053		
0020 E		RBW-BU-B1	3.00 REBUSH A SET OF 2 BOSSES		INCLUDES REAM & POLISH		.23835		.822		
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC				.01001		.011		
0479	JA 01	15	.05		TURN BUSHING GROUP 4/STEEL		.849	.006	.049		1
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS		.49962		.143		
0020 E		RLA-HP-C1	6.00 1ST PART IN-OUT SCROLL CHUCK				.01006		.069		
0030 E		KML-TD-CC	6.00 DIA .501-1.00 REM .033-.250				.10898		.751		
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC				.01001		.011		
0480	JA 01	15	.05		INST/REAM SET FLANGED BUSH		.771	.006	.044		1
0010 E		RBW-BU-B1	.25 SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS		.18669		.053		
0020 E		RBW-BU-B1	3.00 REBUSH A SET OF 2 BOSSES		INCLUDES REAM & POLISH		.23835		.822		
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC				.01001		.011		
0489	JA 01	15	.82		TURN BUSHING GROUP 1/BRONZE		.297	.037	.289		4
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS		.49962		.143		
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK				.01006		.023		
0030 E		KML-TA-FC	2.00 DIA 2.00-3.00 REM .033-.250				.07104		.163		
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC				.01001		.011		
0490	JA 01	15	.82		HAND HONE BUSHING		.389	.048	.347		5
0010 E		RBW-BU-B1	.25 SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS		.18669		.053		

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     0020 E          RBW-BU-A4  2.00 INSTALL ONE STRAIGHT BUSHING                                .02062          .047
     0030 E          RBW-SU-G1   .25 S/U FOR BENCH WORK GENERAL  PRORATE FOUR PARTS              .27525          .079
     0040 N                     2.00                            HONE PART NAME                  .10000          .230
     0060 E          RSG-JP-05  1.00 PREP HAND DRILL CHANGE 1 BIT                               .01603          .018
     0070 E          RBW-BU-P1  2.00 BUTTERFLY POLISH BUSHING I D                              .00333          .007
     0080 E          RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                              .01001          .011
          JA 01  15      .05                                TURN BUSHING GROUP 1/BRONZE      .297   .002     .017     0
     0010 E          RLA-SU-S3   .25 SET UP SMALL MEDIUM LATHE  PRORATE OVER 4 PARTS           .49962          .143
     0020 E          RLA-HP-C1  2.00 1ST PART IN-OUT SCROLL CHUCK                              .01006          .023
     0030 E          KML-TA-FC  2.00 DIA 2.00-3.00 REM .033-.250                               .07104          .163
     0040 E          RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                              .01001          .011
     0500                       XXXXXXXXXXXX
0500      JA 01  15     1.00                                HAND HONE BUSHING                .389   .058     .448     6
     0010 E          RBW-BU-S1   .25 SET UP TO REBUSH BOSSES  PRORATE OVER 4 PARTS             .18669          .053
     0020 E          RBW-BU-A4  2.00 INSTALL ONE STRAIGHT BUSHING                              .02062          .047
     0030 E          RBW-SU-G1   .25 S/U FOR BENCH WORK GENERAL  PRORATE FOUR PARTS            .27525          .079
     0040 N                     2.00                            HONE PART NAME                  .10000          .230
     0060 E          RSG-JP-05  1.00 PREP HAND DRILL CHANGE 1 BIT                               .01603          .018
     0070 E          RBW-BU-P1  2.00 BUTTERFLY POLISH BUSHING I D                              .00333          .007
     0080 E          RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                              .01001          .011
9000      JA 01  15      .01                                LABOR STANDARD HISTORY           .000   .000     .000     0
     0010                       07SEP83 REVIEW & CHG OCC. FACTORS          0.86
     0011                       14NOV84 2 YR REVIEW W/OCC CHANGE > OLD STD <  1.21
     0016                       19MAR85 DOWN GRADED NOT MARKET BASKET
     0900                        J.CALDWELL TECH MANEMA
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TO INTERROGATE LABOR STANDARDS, INPUT

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RCT. PRD MROP NR
   ---X--->
/890123456  ELSE PUT IN END
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OPER SUB STEP	TECH T D	S K L	S W R K	F A C	PF FA DC	A/R SUPPORT ELEMENT	REV OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
RA002	S	E	JA	EA	1	K 88203	1.00	PERCENT ENGR 99.1	MACHINE PISTON ASSY, F15 M.	1.32		1.32	
0001			JA	01	00		.00		PART NUMBER/STOCK NUMBER	.000	.000	.000	0
0030								68A410704-1011	1620010803404				
0040								68A410704-1012	1620010803401				
0050								68A410704-1005	1620010803401				
0060								68A410704-1006	1620010810799				
0030			JA	01	15		.24		NICK AND BURR MEDIUM PART	.077	.003	.021	2
0010	E				RLG-RS-N3		1.00	NICK & BURR MED STRUT PART		.06711		.077	
0020	E				RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0035			JA	01	15		.05		HAND HONE BUSHING	.178	.001	.010	1
0010	E				RDW-SU-G1		.25	S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS	.27525		.079	
0020	N						1.00		HONE PART NAME	.10000		.115	
0030	E				RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0040			JA	01	15		.05		HAND HONE BUSHING	.178	.001	.010	1
0010	E				RDW-SU-G1		.25	S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS	.27525		.079	
0020	N						1.00		HONE PART NAME	.10000		.115	
0030	E				RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0042			JA	01	15		.05		REMOVE 2EA 5° BUSH IN LINE	.093	.001	.005	0
0010	E				RDW-SU-G1		.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27525		.079	
0020	E				RLG-RS-KF		1.00	K/O TYPE 3 BUSH 3-5 IN DIA		.01471		.016	
0030	E				RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
			JA	01	15		.05		REMOVE 2EA 5° BUSH IN LINE	.093	.001	.005	0
0010	E				RDW-SU-G1		.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27525		.079	
0020	E				RLG-RS-KF		1.00	K/O TYPE 3 BUSH 3-5 IN DIA		.01471		.016	
0030	E				RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0048			JA	01	15		1.00		POLISH I.D.	.029	.004	.034	3
0010	E				RSG-JP-05		1.00	PREP HAND DRILL CHANGE 1 BIT		.01603		.018	
0020	E				RDW-BU-P1		1.00	BUTTERFLY POLISH BUSHING I D		.00333		.003	
0030	E				RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0239			JA	01	15		.76		TURN BUSHING GROUP 1/BRONZE	.289	.033	.253	19
0010	E				RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020	E				RLA-HP-C1		2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023	
0030	E				KNL-TA-CC		2.00	DIA .501-1.00 REM .033-.250	2 BUSHINGS	.04699		.154	
0040	E				RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0240			JA	01	15		.76		INST/REAM SET FLANGED BUSH	.295	.034	.258	19
0010	E				RDW-BU-S1		.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020	E				RDW-BU-B1		1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274	
0030	E				RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0244			JA	01	15		.05		TURN BUSHING GROUP 1/BRONZE	.289	.002	.017	1
0010	E				RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020	E				RLA-HP-C1		2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023	
0030	E				KNL-TA-CC		2.00	DIA .501-1.00 REM .033-.250	2 BUSHINGS	.04699		.154	
0040	E				RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0245			JA	01	15		.05		INST/REAM SET FLANGED BUSH	.295	.002	.017	1
0010	E				RDW-BU-S1		.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020	E				RDW-BU-B1		1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274	
0030	E				RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
			JA	01	15		.86		TURN BUSHING GROUP 1/BRONZE	.289	.037	.286	22
0010	E				RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	

0020	E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS			.01006		.023	
0030	E		KNL-TA-CC	2.00	DIA .501-1.00 REM .033-.250 2 BUSHINGS			.04699		.154	
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0250		JA 01	15	.06		INST/REAM SET FLANGED BUSH		.295	.038	.292	22
0010	E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053	
0020	E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH		.23835		.274	
0030	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0254		JA 01	15	.05		TURN BUSHING GROUP 1/"BONZE		.289	.002	.017	1
0010	E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS		.49962		.143	
0020	E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS			.01006		.023	
0030	E		KNL-TA-EC	2.00	DIA 1.50-2.00 REM .033-.250			.06699		.154	
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0255		JA 01	15	.05		INST/REAM SET FLANGED BUSH		.295	.002	.017	1
0010	E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS		.18669		.053	
0020	E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH		.23835		.274	
0030	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0259		JA 01	15	.05		DRILL PISTON HEAD TO PISTON		1.404	.011	.081	6
0010	E		RML-SU-V1	1.00	S/U VERT MILL BORE SMAL FXTR,			.75732		.870	
0020	E		RML-HP-CD	1.00	HOIST HANDLE WRAPPED 2 CLAMP,			.18155		.208	
0030	E		RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS,			.07261		.083	
0040	E		RML-SU-C1	1.00	INSTALL & REMOVE CLAMP ,			.02404		.027	
0050	E		RML-DA-AA	2.00	BORE HOLE 1 X 1/2 GROUP 1 2 EA HOLES			.17936		.412	
0060	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC,			.01001		.011	
9000		JA 01	15	.01		LABOR STANDARD HISTORY		.000	.000	.000	0
0010					06SEP83 REVIEW AND CHG OCC. FACTORS		1.37				
0011					14NOV84 2 YR REVIEW W/OCC CHANGE > OLD STD <		1.19				
0021					18MAR85 DOWN GRADED NOT MARKET BASKET						
022					20NOV85 ADDED TIME TO HONE AXLE ID OLD STD		1.66				
0023					29SEPT86 ADDED SUBOP 0257 OLD STD		1.68				
0900					J CALDWELL TECH MANEAA						

TO INTERROGATE LABOR STANDARDS, INPUT

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 RCC PRD NROP NR
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1234567890123456  ELSE PUT IN END
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STEP	SCH	T	S	K	W	F	PF	A/R	REV	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY	A PCT	A C
RA003	S	N	JA	EA	1		K	88187			.89	PERCENT ENGR 55.5	F-15 MLG ORIFICE TUBE	1.93		1.72			
0001			JA	01		00					.00		PART NUMBER/NSN	.000	.000	.000			0
0010												68A410726-1001	1620003486485						
0025			JA	01		15					.31		POLISH HARD ANODIZE	.361	.017	.129			7
0010	E					RLA-SU-S3					.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143			
0020	E					RLA-HP-C1					2.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.023			
0030	E					KNL-TA-FC					1.00	DIA 2.00-3.00 REM .033-.250		.07104		.081			
0040	E					KNL-TA-FB					11.00	DIA 3.0 REM .250 ADD INCH		.01228		.155			
0050	E					RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0027			JA	01		15					1.00		DISASSEMBLE	.189	.028	.218			11
0010	E					KNL-CD-P1					1.00	CENTER DRILL		.01519		.017			
0020	E					RSG-JP-03					1.00	PREP HAND DRILL FOR USE		.00861		.009			
0030	E					RLA-DR-CA					4.00	DRILL HOLE 1/8-1/4 DIA (1/2		.03903		.179			
0040	E					RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0055			JA	01		15					1.00		POLISH TUBE, 6-8 RMS	.547	.065	.653			34
0010	E					RLA-SU-S3					.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143			
0020	E					RLA-HP-C1					2.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.023			
0030	E					RTL-HN-H1					2.00	NIKE ID OR 2 FLAT SURFACES		.07104		.163			
0040	N										1.00		POLISH O.D.	.25000		.287			
0050	E					ZIT-VI-B1					1.00	VISUAL INSP SMALL CYL I.D.		.02036		.023			
0060	E					RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0070			JA	01		15					1.00		POLISH TUBE, 6-8 RMS	.817	.123	.940			48
0010	E					RLA-SU-S3					.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143			
0020	E					RLA-HP-C1					2.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.023			
0030	E					RTL-HN-H1					2.00	NIKE ID OR 2 FLAT SURFACES		.07104		.163			
0040	N										1.00		POLISH O.D.	.50000		.575			
0050	E					ZIT-VI-B1					1.00	VISUAL INSP SMALL CYL I.D.		.02036		.023			
0060	E					RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
9000			JA	01		00					.00		LABOR STANDARD HISTORY	.000	.000	.000			0
0010												5 JUL 88	INITIAL INPUT						
0900												KIN VINCENT, MANEL, 73952							

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRB MNOP MR
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12345678901234567 ELSE PUT IN ENB

26338A F15 MLG L/H MW RCC MMPRA 4A4-22-3 86224

SUB STEP	T K D L	#R A C	F FA DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
RA004	S E	JA EA	1	J 88187	.05	PERCENT ENGR 99.9	F-15 TORQUE ARM	.13		.00	
0001		JA 01	00		.00		PART NUMBER/NSN	.000	.000	.000	0
0010						68A410646-2005	1620001386306				
0025		JA 01	15		1.00		REMOVE TOR ARM PIN	.086	.013	.100	75
0010	E		RBW-SU-G1		.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27525		.079	
0020	E		RLG-RS-KA		1.00	K/O SINGLE BUSH 1/4-1 IN DIA	REMOVE BUSHING WITH KNOCKER	.00780		.008	
0030	E		RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0030		JA 01	15		1.00		O/S LOCK PIN	.029	.004	.034	25
0010	E		RSG-JP-05		1.00	PREP HAND DRILL CHANGE 1 BIT		.01603		.018	
0020	E		RBW-BU-P1		1.00	BUTTERFLY POLISH BUSHING I D		.00333		.003	
0030	E		RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000		JA 01	00		.00		LABOR STANDARD HISTORY	.000	.000	.000	0
0001						5 JULY 88	INITIAL INPUT				
0900						KIM VINCENT, MANEL 73255					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR
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390123456 ELSE PUT IN END

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 09/16/88 A-E046B-MM1-DY-M45 PAGE 0001

26338A F15 MLG L/H MW RCC MNPRA 4A4-22-3 86224

SUB STEP	T D	K L	$R K	A C	F DC	PF ELEMENT	A/R FACT	REV	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT	C
A007	S	E JA	EA	1		K 88190	1.00		PERCENT ENGR 99.9	F-15 MAIN TRUNNION PIN	.03		.03		
0001		JA 01		15			.00			PART NUMBER/ NSN	.000	.000	.000	0	
0010									68A410735-2001	1620003386529					
0030		JA 01		15			1.00				.030	.005	.035	100	
0010	E			RSG-JP-03			.25		PREP HAND DRILL FOR USE	PRORATED OVER 4 PARTS	.00861		.002		
0020	E			GTL-DD-A4			2.00		DRILL HOLE W/PORTABLE DRILL	DRILL CROSS BOLT HOLE 2 HOLE	.00924		.021		
0030	E			RJP-PW-R1			1.00		REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000		JA 01		00			.00			LABOR STANDRD HISTORY	.000	.000	.000	0	
0900									8 APR. 1988 RICHARD G. MARTIN MANEL-73357-MRPII						

TO INTERROGATE LABOR STANDARDS, INPUT

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 RCC PRD MROP NR
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1234567890123456  ELSE PUT IN END
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SUB STEP	TECH S S T K D L	W F PF A/R REV K C DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
RA008	S E	JA EA 1	J 88188	.05	PERCENT ENGR 99.9	F-15M LOWER DRAG BRACE	2.38		.11	
0001		JA 01	00	.00		PART NUMBER/NSN	.000	.000	.000	0
0010					68A410792-1001	1620003654004				
0040		JA 01	15	1.00		LOCATE & DRILL 1 HOLE	.072	.011	.084	4
0010	E		KML-CD-P1	1.00	CENTER DRILL		.01519		.017	
0020	E		RSG-JP-03	1.00	PREP HAND DRILL FOR USE		.00861		.009	
0030	E		RLA-DR-CA	1.00	DRILL HOLE 1/8-1/4 DIA (1/2		.03903		.044	
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0042		JA 01	15	.05		O/S HOLE ON MILL/SMALL PART	.781	.006	.045	2
0010	E		KMM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.145	
0020	E		RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030	E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040	E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E		RML-BD-BB	1.00	BORE HOLE 1.5 X 1 GROUP 4	USE PROPER ELEMENT/TABLE	.35729		.410	
0060	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0044		JA 01	15	.05		O/S HOLE ON MILL/SMALL PART	.781	.006	.045	2
0010	E		KMM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.145	
0020	E		RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030	E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040	E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E		RML-BD-BB	1.00	BORE HOLE 1.5 X 1 GROUP 4	USE PROPER ELEMENT/TABLE	.35729		.410	
0060	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
46		JA 01	15	.05		O/S HOLE ON MILL/SMALL PART	.911	.007	.052	2
0010	E		KMM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.145	
0020	E		RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030	E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040	E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E		RML-BD-BD	1.00	BORE HOLE 1.5 X 2 GROUP 4	USE PROPER ELEMENT/TABLE	.48689		.559	
0060	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0100		JA 01	15	.05		O/S HOLE ON MILL/SMALL PART	.640	.005	.037	2
0010	E		KMM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.145	
0020	E		RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030	E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040	E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E		RML-BA-CD	1.00	BORE HOLE 2 X 2 GROUP 1	USE PROPER ELEMENT/TABLE	.21626		.248	
0060	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0101		JA 01	15	.05		INST STRAIGHT BUSH NO POLISH	.077	.001	.004	0
0010	E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020	E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0105		JA 01	15	.05		NICK AND BURR SMALL PART	.055	.000	.003	0
0010	E		RLG-RS-N4	1.00	NICK & BURR SMALL STRUT PART		.04595		.052	
0030	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0109		JA 01	15	1.00		TURN BUSHING GROUP 1/BRONZE	.289	.043	.332	14
0010	E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020	E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.023	
0030	E		KML-TA-EC	2.00	DIA 1.50-2.00 REM .033-.250		.06699		.154	
0040	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
J		JA 01	15	1.00		INST/REAM SET FLANGED BUSH	.295	.044	.339	14

0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020 E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274		
030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
	JA 01	15	.05		TURN BUSHING GROUP 1/BRONZE	.289	.002	.017		1
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.023		
0030 E		KML-TA-EC	2.00	DIA 1.50-2.00 REM .033-.250		.06699		.154		
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0115	JA 01	15	.05		INST/REAM SET FLANGED BUSH	.295	.002	.017		1
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020 E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274		
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0119	JA 01	15	1.00		TURN BUSHING GROUP 1/BRONZE	.289	.043	.332		14
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.023		
0030 E		KML-TA-EC	2.00	DIA 1.50-2.00 REM .033-.250		.06699		.154		
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0120	JA 01	15	1.00		INST/REAM SET FLANGED BUSH	.295	.044	.339		14
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020 E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274		
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0124	JA 01	15	.05		TURN BUSHING GROUP 1/BRONZE	.289	.002	.017		1
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.023		
0030 E		KML-TA-EC	2.00	DIA 1.50-2.00 REM .033-.250		.06699		.154		
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0125	JA 01	15	.05		INST/REAM SET FLANGED BUSH	.295	.002	.017		1
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020 E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274		
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0129	JA 01	15	1.00		TURN BUSHING GROUP 1/BRONZE	.289	.043	.332		14
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.023		
0030 E		KML-TA-EC	2.00	DIA 1.50-2.00 REM .033-.250		.06699		.154		
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0130	JA 01	15	1.00		INST/REAM SET FLANGED BUSH	.295	.044	.339		14
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020 E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274		
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0134	JA 01	15	.05		TURN BUSHING GROUP 1/BRONZE	.289	.002	.017		1
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.023		
0030 E		KML-TA-EC	2.00	DIA 1.50-2.00 REM .033-.250		.06699		.154		
0040 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0135	JA 01	15	.05		INST/REAM SET FLANGED BUSH	.295	.002	.017		1
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020 E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274		
0030 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000	JA 01	00	.00		LABOR STANDARD HISTORY	.000	.000	.000		0
0010				7 JUL 88	INITIAL INPUT					
0900				KIM VINCENT, MANEL, 73255						

ROGATE LABOR STANDARDS, INPUT

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 07/28/88 A-E046B-MM1-DY-M45 PAGE 0001

26338A F15 MLG L/H HW RCC MNPRA 4A4-22-3 86224

SUB STEP	TECH D	S T L	S K	W R C	F A DC	PF FA	A/R SUPPORT ELEMENT	REV OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
RA009	S	E	JA	EA	1	J	88194	1.00	PERCENT ENGR 99.9	F-15 M JURY LINK PIN	.03		.03		
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000	0	
0010									68A410756-1001	1620003386530					
0030			JA	01	15			1.00		MACH. CROSS BOLT HOLES	.030	.005	.035	100	
0010	E				RSG-JP-03			.25	PREP HAND DRILL FOR USE	PRORATED OVER 4 PARTS	.00861		.002		
0020	E				GTL-DD-A4			2.00	DRILL HOLE W/PORTABLE DRILL	DRILL CROSS BOLT HOLE 2 HOLE	.00924		.021		
0030	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000			JA	01	00			.00		LABOR STANDARD HISTORY	.000	.000	.000	0	
0010									12 JUL 88	INITIAL INPUT					
0900									KIM VINCENT, MANEL, 73952						

TO INTERROGATE LABOR STANDARDS, INPUT

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 RCC PRD MROP NR
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26338A F15 MLG L/H HW RCC MNPRA 4A4-22-3 86224

SUB STEP	TECH D	S T	S K	W #R	F A	PF C	A/R FA	REV DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
RA010	S	E	JA	EA	1		K	88189		.07	PERCENT ENGR 83.9	F-15 MAIN LOWER JURY LINK	1.43		.10		
0001			JA	01		00				.00		PART NUMBER/NSN	.000	.000	.000		0
0010											68A410795-1003	1620010360263					
0042			JA	01		15				.05		POLISH I.D.	.029	.000	.002		0
0010	E				RSG	JP	05			1.00	PREP HAND DRILL CHANGE 1 BIT		.01603		.018		
0020	E				RBW	BU	P1			1.00	BUTTERFLY POLISH BUSHING I D		.00333		.003		
0030	E				RJP	PW	R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0044			JA	01		15				.05		OVERSIZE HOLE WITH REAMER	.349	.003	.020		1
0010	E				RBW	BU	S1			.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E				RLG	HP	V7			1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078		
0030	E				RBW	BU	R2			3.00	REAM WITH LEMPCO REAMER	3 PASSES	.07337		.253		
0040	E				RBW	DB	A1			1.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.004		
0050	E				RJP	PW	R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0046			JA	01		15				.05		OVERSIZE HOLE WITH REAMER	.349	.003	.020		1
0010	E				RBW	BU	S1			.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E				RLG	HP	V7			1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078		
0030	E				RBW	BU	R2			3.00	REAM WITH LEMPCO REAMER	3 PASSES	.07337		.253		
0040	E				RBW	DB	A1			1.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.004		
0050	E				RJP	PW	R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0048			JA	01		15				.05		O/S HOLE ON MILL/SMALL PART	.630	.005	.036		3
0010	E				KMM	SU	V1			.25	S/U VERT MILL BORE SMAL FXTR	PRORATE OVER 4 PARTS	.50518		.145		
0020	E				RML	HP	CA			1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
0030	E				RML	AL	AB			1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E				RML	AL	AC			1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E				RML	BA	BD			1.00	BORE HOLE 1.5 X 2 GROUP 1	USE PROPER ELEMENT/TABLE	.20600		.236		
0060	E				RJP	PW	R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0059			JA	01		15				1.00		TURN BUSHING GROUP 1/BRONZE	.443	.066	.510		36
0010	E				RLA	SU	S3			.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E				RLA	HP	C1			4.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.046		
0030	E				KML	TA	CC			4.00	DIA .501-1.00 REM .033-.250	2 BUSHINGS	.06699		.308		
0040	E				RJP	PW	R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0060			JA	01		15				1.00		INST/REAM SET FLANGED BUSH	.295	.044	.339		24
0010	E				RBW	BU	S1			.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E				RBW	BU	B1			1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274		
0030	E				RJP	PW	R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0064			JA	01		15				.05		TURN BUSHING GROUP 1/BRONZE	.443	.003	.025		2
0010	E				RLA	SU	S3			.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E				RLA	HP	C1			4.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.046		
0030	E				KML	TA	CC			4.00	DIA .501-1.00 REM .033-.250	2 BUSHINGS	.06699		.308		
0040	E				RJP	PW	R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0065			JA	01		15				.05		INST/REAM SET FLANGED BUSH	.295	.002	.017		1
0010	E				RBW	BU	S1			.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E				RBW	BU	B1			1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274		
0030	E				RJP	PW	R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0069			JA	01		15				.50		INST STRAIGHT BUSH NO POLISH	.077	.006	.044		3
0010	E				RBW	BU	S1			.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E				RBW	BU	A4			1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023		
0030	E				RJP	PW	R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0070			JA	01		15				1.00		HONE BUSHING/SUNNEN STROKER	.163	.025	.188		13

0010	E	ZHO-SU-S2	.25	SETUP SUNNEN HONE STROKER	PRORATE FOUR PARTS	.21517		.061		
0020	N		1.00		HONE BUSHING	.10000		.115		
30	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
72	JA 01	15	.05		MACH O/S DRAG BRACE	.289	.002	.017		1
0010	E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E	RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023		
0030	E	KML-TA-CC	2.00	DIA .501-1.00 REM .033-.250	2 BUSHINGS	.06699		.154		
0040	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0074	JA 01	15	.05		INSTALL O/S DRAG BRACE	.077	.001	.004		0
0010	E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023		
0030	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0075	JA 01	15	1.00		HONE BUSHING/SUNNEN STROKER	.163	.025	.188		13
0010	E	ZHO-SU-S2	.25	SETUP SUNNEN HONE STROKER	PRORATE FOUR PARTS	.21517		.061		
0020	N		1.00		HONE BUSHING	.10000		.115		
0030	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0077	JA 01	15	.05		MACH O/S GROUND BOSS	.289	.002	.017		1
0010	E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E	RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023		
0030	E	KML-TA-CC	2.00	DIA .501-1.00 REM .033-.250	2 BUSHINGS	.06699		.154		
0040	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0078	JA 01	15	.05		INSTALL O/S GROUND BOSS	.077	.001	.004		0
0010	E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023		
0030	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000	JA 01	24	.01		LABOR STANDARD HISTORY	.000	.000	.000		0
0010				13SEP83 NEW INPUT-NO OCC FACTOR HISTORY						
0011				14NOV84 2 YR REVIEW W/NO CHANGE						
0012				18MAR85 DOWN GRADED NOT MARKET BASKET						
0013				25NOV85 CHANGED SUBOPS TO MATCH 958 OLD STD .29						
0900				J.CALDWELL TECH MANEAA						

TO INTERROGATE LABOR STANDARDS, INPUT

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OPE STEP	CH	T D	S L	S K	W R	F K	PF A	A/R C	REV FA DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY	A PCT	A C
RA011	S	E	JA	EA	1	K	88195				.70	PERCENT ENGR 94.8	F-15M UPPER JURY LINK	2.08		1.45			
0001			JA	01		00					.00		PART NUMBER/NSN	.000	.000	.000			0
0010												68A410794-1006	1620010403580						
0020												68A410794-1005	1620010483581						
0021			JA	01		15					.26		REMOVE BUSHING/1" DIA	.086	.003	.026			1
0010	E					RBW-SU-G1					.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27525		.079			
0020	E					RLG-RS-KA					1.00	K/O SINGLE BUSH 1/4-1 IN DIA	REMOVE BUSHING WITH KNOCKER	.00780		.008			
0030	E					RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0022			JA	01		15					1.00		REMOVE BUSHING/1" DIA	.102	.015	.118			6
0010	E					RBW-SU-G1					.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27525		.079			
0020	E					RLG-RS-KA					3.00	K/O SINGLE BUSH 1/4-1 IN DIA	REMOVE BUSHING WITH KNOCKER	.00780		.026			
0030	E					RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0023			JA	01		15					.95		POLISH I.D.	.029	.004	.032			2
0010	E					RSG-JP-05					1.00	PREP HAND DRILL CHANGE 1 BIT		.01603		.018			
0020	E					RBW-BU-P1					1.00	BUTTERFLY POLISH BUSHING I D		.00333		.003			
0030	E					RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0025			JA	01		15					1.00		TURN BUSHING GROUP 4/STEEL	.317	.048	.365			18
0010	E					RLA-SU-S3					.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143			
0020	E					RLA-HP-C1					1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011			
0030	E					KML-TD-EC					1.00	DIA 1.50-2.00 REM .033-.250		.17225		.198			
0040	E					RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0026			JA	01		15					.05		O/S HOLE ON MILL/SMALL PART	.640	.005	.037			2
0010	E					KMM-SU-V1					.25	S/U VERT MILL BORE SMAL FXTR	PRORATE OVER 4 PARTS	.50518		.145			
0020	E					RML-HP-CA					1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098			
0030	E					RML-AL-AB					1.00	ALIGN VERTICAL AXIS ROD		.12699		.146			
0040	E					RML-AL-AC					1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087			
0050	E					RML-BA-CD					1.00	BORE HOLE 2 X 2 GROUP 1	USE PROPER ELEMENT/TABLE	.21626		.248			
0060	E					RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0035			JA	01		15					.26		OVERSIZE HOLE WITH REAMER	.349	.014	.104			5
0010	E					RBW-BU-S1					.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053			
0020	E					RLG-HP-V7					1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078			
0030	E					RBW-BU-R2					3.00	REAM WITH LEMPCO REAMER	3 PASSES	.07337		.253			
0040	E					RBW-DB-A1					1.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.004			
0050	E					RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0038			JA	01		15					1.00		NICK AND BURR SMALL PART	.055	.008	.064			3
0010	E					RLG-RS-N4					1.00	NICK & BURR SMALL STRUT PART		.04595		.052			
0030	E					RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0200			JA	01		15					.26		INSTALL BEARING	.089	.004	.027			1
0010	E					RBW-SU-G1					.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27525		.079			
0020	E					RLG-RS-K1					1.00	REM BUSHING (1ST OR SINGLE)		.01099		.012			
0030	E					RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0201			JA	01		15					1.00		TURN BUSHING GROUP 1/BRONZE	.240	.036	.276			13
0010	E					RLA-SU-S3					.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143			
0020	E					RLA-HP-C1					1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011			
0030	E					KML-TA-CC					1.00	DIA .501-1.00 REM .033-.250		.06699		.077			
0040	E					KML-TA-CD					3.00	DIA 1.0 REMOVE .250 ADD INCH		.00947		.032			
0050	E					RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0203			JA	01		15					1.00		INST STRAIGHT BUSH NO POLISH	.077	.012	.089			4
10	E					RBW-BU-S1					.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053			

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    0020 E        RBW-BU-A4  1.00 I.  . ONE STRAIGHT BUSHING                          .02062          .023
    0030 E        RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                       .01001          .011
0205      JA 01   15         1.00                          TURN BUSHING GROUP 1/BRONZE  .259  .039  .299   14
    0010 E        RLA-SU-S3   .25 SET UP SMALL MEDIUM LATHE  PRORATE OVER 4 PARTS     .49962          .143
    0020 E        RLA-HP-C1  1.00 1ST PART IN-OUT SCROLL CHUCK                       .01006          .011
    0030 E        KML-TA-CC  1.00 DIA .501-1.00 REM .033-.250                        .06699          .077
    0040 E        KML-TA-CD  3.00 DIA 1.0 REMOVE .250 ADD INCH                       .00947          .032
    0050 E        RSG-JP-05  1.00 PREP HAND DRILL CHANGE 1 BIT                       .01603          .018
    0060 E        RBW-BU-P1  1.00 BUTTERFLY POLISH BUSHING I D                       .00333          .003
    0070 E        RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                       .01001          .011
0206      JA 01   15          .89                          TURN BUSHING GROUP 1/BRONZE  .307  .041  .315   15
    0010 E        RLA-SU-S3   .25 SET UP SMALL MEDIUM LATHE  PRORATE OVER 4 PARTS     .49962          .143
    0020 E        RLA-HP-C1  2.00 1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS            .01006          .023
    0030 E        KML-TA-CC  2.00 DIA .501-1.00 REM .033-.250                        .06699          .154
    0040 E        KML-TA-CD  2.00 DIA 1.0 REMOVE .250 ADD INCH                       .00947          .021
    0050 E        RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                       .01001          .011
0208      JA 01   15          .89                          INST SET FLANGED BUSHINGS    .108  .014  .111    5
    0010 E        RBW-BU-S1   .25 SET UP TO REBUSH BOSSES  PRORATE OVER 4 PARTS      .18669          .053
    0020 E        RBW-BU-A1  1.00 INSTALL SET FLANGED BUSHINGS NO POLISH             .05133          .059
    0030 E        RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                       .01001          .011
0210      JA 01   15          .89                          HONE BUSHING/SUNNEN STROKER  .183  .024  .187    9
    0010 E        ZHO-SU-S2   .25 SETUP SUNNEN HONE STROKER  PRORATE FOUR PARTS      .21517          .061
    0020 N                   1.00                          HONE BUSHING               .10000          .115
    0030 E        RSG-JP-05  1.00 PREP HAND DRILL CHANGE 1 BIT                       .01603          .018
    0040 E        RBW-BU-P1  1.00 BUTTERFLY POLISH BUSHING I D                       .00333          .003
    0050 E        RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                       .01001          .011
0212      JA 01   15          .05                          TURN BUSHING GROUP 1/BRONZE  .307  .002  .018    1
    0010 E        RLA-SU-S3   .25 SET UP SMALL MEDIUM LATHE  PRORATE OVER 4 PARTS     .49962          .143
    0020 E        RLA-HP-C1  2.00 1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS            .01006          .023
    0030 E        KML-TA-CC  2.00 DIA .501-1.00 REM .033-.250                        .06699          .154
    0040 E        KML-TA-CD  2.00 DIA 1.0 REMOVE .250 ADD INCH                       .00947          .021
    0050 E        RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                       .01001          .011
0215      JA 01   15          .05                          INST SET FLANGED BUSHINGS    .108  .001  .006    0
    0010 E        RBW-BU-S1   .25 SET UP TO REBUSH BOSSES  PRORATE OVER 4 PARTS      .18669          .053
    0020 E        RBW-BU-A1  1.00 INSTALL SET FLANGED BUSHINGS NO POLISH             .05133          .059
    0030 E        RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                       .01001          .011
0217      JA 01   15          .05                          HONE BUSHING/SUNNEN STROKER  .183  .001  .011    1
    0010 E        ZHO-SU-S2   .25 SETUP SUNNEN HONE STROKER  PRORATE FOUR PARTS      .21517          .061
    0020 N                   1.00                          HONE BUSHING               .10000          .115
    0030 E        RSG-JP-05  1.00 PREP HAND DRILL CHANGE 1 BIT                       .01603          .018
    0040 E        RBW-BU-P1  1.00 BUTTERFLY POLISH BUSHING I D                       .00333          .003
    0050 E        RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                       .01001          .011
9000      JA 01   00          .00                          LABOR STANDRD HISTORY        .000  .000  .000    0
    0900                        8 APR. 1988  RICHARD G. MARTIN  MANEL-73357-MRPII
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TO INTERROGATE LABOR STANDARDS, INPUT

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SUB STEP	TECH	T	S K	S #R	W A	F C	PF DC	A/R FA	REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT	C
RA013	S	E	JA	EA	1		J	88197		1.00	PERCENT ENGR 99.9	F-15M SPINDLE ASSY	1.10		1.10		
0001			JA	01	00					.00		PART NUMBER/NSN	.000	.000	.000		0
0010											68A410624-1001	1620003337133					
0030			JA	01	15					1.00		OVERSIZE HOLE WITH REAMER	.349	.052	.402		36
0010	E				RBW-BU-S1					.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E				RLG-HP-V7					1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078		
0030	E				RBW-BU-R2					3.00	REAM WITH LEMPCO REAMER	3 PASSES	.07337		.253		
0040	E				RBW-DB-A1					1.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.004		
0050	E				RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0197			JA	01	15					1.00		TURN BUSHING GROUP 1/BRONZE	.289	.043	.332		30
0010	E				RLA-SU-S3					.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E				RLA-HP-C1					2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023		
0030	E				KML-TA-CC					2.00	DIA .501-1.00 REM .033-.250	2 BUSHINGS	.06699		.154		
0040	E				RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0200			JA	01	15					1.00		INST/REAM SET FLANGED BUSH	.295	.044	.339		31
0010	E				RBW-BU-S1					.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E				RBW-BU-B1					1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274		
0030	E				RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0204			JA	01	15					.05		TURN BUSHING GROUP 1/BRONZE	.289	.002	.017		2
0010	E				RLA-SU-S3					.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E				RLA-HP-C1					2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023		
0030	E				KML-TA-CC					2.00	DIA .501-1.00 REM .033-.250	2 BUSHINGS	.06699		.154		
0040	E				RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0205			JA	01	15					.05		INST/REAM SET FLANGED BUSH	.295	.002	.017		2
0010	E				RBW-BU-S1					.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E				RBW-BU-R1					1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23935		.274		
0030	E				RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000			JA	01	00					.00		LABOR STANDARD HISTORY	.000	.000	.000		0
0010											15 JUL 88	INITIAL INPUT					
0900											KIM VINCENT, MANEL, 73255						

TO INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 09/16/88 A-E046B-MM1-DY-M45 PAGE 0001

26338A F15 MLG L/H HW RCC MNPRA 4A4-22-3 86224

OPER SUB STEP	TECH D	S S T K L	W F PF A/R REV #R A C DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
RA014	S	E JA EA 1	K 88196		.57	PERCENT ENGR 99.9	F-15 M DRAG BOLT	.78		.44	
0001		JA 01	00		.00		PART NUMBER/NSN	.000	.000	.000	0
0010						68A410637-1001 NSL					
0030		JA 01	15		.05		OVERSIZE HOLE WITH REAMER	.349	.003	.020	3
0010	E		RBW-BU-S1		.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020	E		RLG-HP-V7		1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078	
0030	E		RBW-BU-R2		3.00	REAM WITH LEMPCO REAMER	3 PASSES	.07337		.253	
0040	E		RBW-DB-A1		1.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.004	
0050	E		RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0045		JA 01	15		.10		RECENTER PIN--60--	.472	.007	.054	7
0010	E		RLA-SU-S3		.50	SET UP SMALL MEDIUM LATHE	PRORATE 2 PARTS	.49962		.287	
0020	E		RLA-HP-C3		2.00	CHUCK SYMET PART IN 4 JAW	BOTH SIDES	.09095		.209	
0030	E		KML-CD-P1		2.00	CENTER DRILL		.01519		.034	
0050	E		RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0189		JA 01	15		1.00		TURN BUSHING GROUP 1/BRONZE	.289	.043	.332	42
0010	E		RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020	E		RLA-HP-C1		2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023	
0030	E		KML-TA-CC		2.00	DIA .501-1.00 REM .033-.250	2 BUSHINGS	.06699		.154	
0040	E		RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0190		JA 01	15		1.00		INST/REAM SET FLANGED BUSH	.295	.044	.339	43
0010	E		RBW-BU-S1		.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020	E		RBW-BU-B1		1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274	
0030	E		RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0194		JA 01	15		.06		TURN BUSHING GROUP 1/BRONZE	.289	.003	.020	3
0010	E		RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020	E		RLA-HP-C1		2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023	
0030	E		KML-TA-CC		2.00	DIA .501-1.00 REM .033-.250	2 BUSHINGS	.06699		.154	
0040	E		RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0195		JA 01	15		.06		INST/REAM SET FLANGED BUSH	.295	.003	.020	3
0010	E		RBW-BU-S1		.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020	E		RBW-BU-B1		1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274	
0030	E		RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000		JA 01	00		.00		LABOR STANDARD HISTORY	.000	.000	.000	0
0010						14 JUL 88	INITIAL INPUT				
0900						KIM VINCENT, MANEL, 73255					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR
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1234567890123456 ELSE PUT IN END

TECH S S W F PF A/R REV

SUB STEP	T K D L	#R K	A C	FA DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
RA016	S E	JA EA	1	J	88196	.26	PERCENT ENGR 99.7	F-15 M COLLAR ASSY	2.35		.61	
0001		JA 01		00		.00		PART NUMBER/NSN	.000	.000	.000	0
0010							68A410733-1001	1620003440616				
0020							68A410733-1002	1620003386559				
0030		JA 01		15		.05		TURN BUSHING GROUP 4/STEEL	2.073	.016	.119	5
0010	E			RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020	E			RLA-HP-C1		1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030	E			KML-TD-JC		3.00	DIA 5.00-6.00 REM .033-.250		.40208		1.387	
0040	E			KML-TD-JD		3.00	DIA 6.00 REM .250 ADD INCH		.24071		.830	
0050	E			RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0040		JA 01		15		.05		HAND HONE BUSHING	.178	.001	.010	0
0010	E			RBW-SU-G1		.25	S/U FOR BENCH WORK GENERAL	PRORATE FOUR PARTS	.27525		.079	
0020	N					1.00		HONE PART NAME	.10000		.115	
0030	E			RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0050		JA 01		15		.05		O/S HOLE ON MILL/SMALL PART	.739	.006	.042	2
0010	E			KMM-SU-V1		.25	S/U VERT MILL BORE SMAL FXTR	PRORATE OVER 4 PARTS	.50518		.145	
0020	E			RML-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030	E			RML-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040	E			RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E			RML-BD-AB		1.00	BORE HOLE 1 X 1 GROUP 4	USE PROPER ELEMENT/TABLE	.31431		.361	
0060	E			RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
)		JA 01		15		.09		O/S HOLE ON MILL/SMALL PART	.739	.010	.076	3
0010	E			KMM-SU-V1		.25	S/U VERT MILL BORE SMAL FXTR	PRORATE OVER 4 PARTS	.50518		.145	
0020	E			RML-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030	E			RML-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040	E			RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E			RML-BD-AB		1.00	BORE HOLE 1 X 1 GROUP 4	USE PROPER ELEMENT/TABLE	.31431		.361	
0060	E			RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0139		JA 01		15		.86		INST STRAIGHT BUSH NO POLISH	.097	.013	.097	4
0010	E			RBW-BU-S1		.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020	E			RBW-BU-A4		2.00	INSTALL ONE STRAIGHT BUSHING		.02062		.047	
0030	E			RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0140		JA 01		15		.86		TURN BUSHING GROUP 4/STEEL	.373	.048	.369	16
0010	E			RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020	E			RLA-HP-C1		2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023	
0030	E			KML-TD-CC		2.00	DIA .501-1.00 REM .033-.250		.10898		.250	
0040	E			RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0148		JA 01		15		.14		TURN BUSHING GROUP 4/STEEL	.373	.008	.060	3
0010	E			RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020	E			RLA-HP-C1		2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023	
0030	E			KML-TD-CC		2.00	DIA .501-1.00 REM .033-.250		.10898		.250	
0040	E			RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0149		JA 01		15		.14		INST STRAIGHT BUSH NO POLISH	.077	.002	.012	1
0010	E			RBW-BU-S1		.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020	E			RBW-BU-A4		1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030	E			RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
150		JA 01		15		.14		TURN BUSHING GROUP 4/STEEL	.373	.008	.060	3
010	E			RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
020	E			RLA-HP-C1		2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023	

0030 E		KML-TD-CC	2.00 DIA .501-1.00 REM .033-.250			.10898		.250	
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01004		.011	
	JA 01	15	.57		INST/REAM SET FLANGED BUSH	.175	.015	.115	5
.010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	.50 REBUSH A SET OF 2 BOSSES		INCLUDES REAM & POLISH	.23835		.137	
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0169	JA 01	15	.09		TURN BUSHING GROUP 1/BRONZE	.221	.003	.023	1
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK			.01006		.011	
0030 E		KML-TA-CC	1.00 DIA .501-1.00 REM .033-.250			.06699		.077	
0040 E		KML-TA-CD	1.00 DIA 1.0 REMOVE .250 ADD INCH			.00947		.010	
0050 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0170	JA 01	15	.09		INST/REAM SET FLANGED BUSH	.175	.002	.018	1
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	.50 REBUSH A SET OF 2 BOSSES		INCLUDES REAM & POLISH	.23835		.137	
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0180	JA 01	15	1.00		INST/REAM SET FLANGED BUSH	.175	.026	.202	9
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	.50 REBUSH A SET OF 2 BOSSES		INCLUDES REAM & POLISH	.23835		.137	
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0189	JA 01	15	.29		TURN BUSHING GROUP 1/BRONZE	.221	.010	.074	3
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK			.01006		.011	
0030 E		KML-TA-CC	1.00 DIA .501-1.00 REM .033-.250			.06699		.077	
0040 E		KML-TA-CD	1.00 DIA 1.0 REMOVE .250 ADD INCH			.00947		.010	
0050 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0190	JA 01	15	.29		INST/REAM SET FLANGED BUSH	.175	.008	.059	2
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	.50 REBUSH A SET OF 2 BOSSES		INCLUDES REAM & POLISH	.23835		.137	
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0199	JA 01	15	.57		TURN BUSHING GROUP 1/BRONZE	.289	.025	.189	8
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS			.01006		.023	
0030 E		KML-TA-EC	2.00 DIA 1.50-2.00 REM .033-.250			.06699		.154	
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0200	JA 01	15	.57		INST STRAIGHT BUSH NO POLISH	.097	.008	.064	3
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A4	2.00 INSTALL ONE STRAIGHT BUSHING			.02062		.047	
0030 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0209	JA 01	15	.09		TURN BUSHING GROUP 1/BRONZE	.289	.004	.030	1
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS			.01006		.023	
0030 E		KML-TA-EC	2.00 DIA 1.50-2.00 REM .033-.250			.06699		.154	
0040 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0210	JA 01	15	1.00		O/S HOLE ON MILL/SMALL PART	.640	.096	.737	31
0010 E		KMM-SU-V1	.25 S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS			.50518		.145	
0020 E		RML-HP-CA	1.00 HAND HANDLE NO WRAP 2 CLAMPS			.08531		.098	
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD			.12699		.146	
0040 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD			.07609		.087	
0050 E		RML-BA-CD	1.00 BORE HOLE 2 X 2 GROUP 1		USE PROPER ELEMENT/TABLE	.21626		.248	
0060 E		RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
9000	JA 01	00	.00		LABOR STANDARD HISTORY	.000	.000	.000	0
0010			14 JUL 88		INITIAL INPUT				
0900			KIM VINCENT, MANEL, 73255						

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 07/28/88 A-E046B-MM1-DY-M45 PAGE 0001

26338A F15 MLG L/H HW RCC MNPRA 4A4-22-3 86224

SUB STEP	TECH	S T	S K	W R	F A	PF FA	A/R DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT	C
RA020		S	E	JA	EA	1	J	88196	.75	PERCENT ENGR 99.9	F-15 MAIN SPRING	.20		.15		
0001			JA	01		00			.00		PART NUMBER/NSN	.000	.000	.000	0	
0010										68A410725-1001	1620001323253					
0020										68A410725-1002	1620001323209					
0040			JA	01		15			1.00		REMOVE BUSHING	.094	.014	.109	54	
0010	E				RBW	SU	G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27525		.079		
0020	E				RLG	RS	KA	2.00	K/O SINGLE BUSH 1/4-1 IN DIA	REMOVE BUSHING WITH KNOCKER	.00780		.017		
0030	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0140			JA	01		15			1.00		INSTALL BUSHING	.079	.012	.092	46	
0010	E				RBW	BU	S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E				RBW	BU	A2	1.00	INSTALL SET STRAIGHT BUSHING	NO POLISH	.02299		.026		
0030	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000			JA	01		00			.00		LABOR STANDARD HISTORY	.000	.000	.000	0	
0010										14 JUL 88	INITIAL INPUT					
0900										KIM VINCENT, MANEL, 73255						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR
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OPER SUB STEP	TECH D	S L	S K	W R	F A	PF FA	A/R SUPPORT ELEMENT	REV OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY	PCT C
5A022	S	E	JA	EA	1	J	88292	1.00	PERCENT ENGR 99.9	MACH COLLAR TRUNNION F15M	4.11		4.11		
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010									68A410638-1009	1620010753563					
0020									68A410638-1005	1620010395815					
0070			JA	01	15			1.00		OVERSIZE HOLE WITH REAMER	.349	.052	.402		10
0010	E				RBW-BU-S1			.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E				RLG-HP-V7			1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078		
0030	E				RBW-BU-R2			3.00	REAM WITH LEMPCO REAMER	3 PASSES	.07337		.253		
0040	E				RBW-DB-A1			1.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.004		
0050	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0080			JA	01	15			1.00		OVERSIZE HOLE WITH REAMER	.798	.120	.918		22
0010	E				RBW-BU-S1			.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E				RLG-HP-V7			1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078		
0030	E				RBW-BU-R2			9.00	REAM WITH LEMPCO REAMER	3 PASSES	.07337		.759		
0040	E				RBW-DB-A1			3.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.014		
0050	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0090			JA	01	15			1.00		TURN BUSHING GROUP 4/STEEL	.705	.106	.812		20
0010	E				RLA-SU-S3			.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E				RLA-HP-C1			2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023		
0030	E				KML-TD-GC			2.00	DIA 3.00-4.00 REM .033-.25%		.27540		.633		
0040	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0095			JA	01	15			1.00		REIDENTIFY / METAL STAMP	.062	.012	.095		2
0010	E				RBW-SU-G1			.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27525		.079		
0020	E				GID-SA-A1			1.00	STAMP WITH METAL STAMP		.00342		.003		
0030	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0350			JA	01	15			1.00		TURN BUSHING GROUP 4/STEEL	.492	.074	.566		14
0010	E				RLA-SU-S3			.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E				RLA-HP-C1			3.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.034		
0030	E				KML-TD-CC			3.00	DIA .501-1.00 REM .033-.250		.10898		.375		
0040	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0360			JA	01	15			1.00		INST/REAM SET STRAIGHT BUSH	.723	.109	.832		20
0010	E				RBW-BU-S1			.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E				RBW-BU-B2			3.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.22231		.766		
0030	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0370			JA	01	15			1.00		TURN BUSHING GROUP 4/STEEL	.253	.038	.292		7
0010	E				RLA-SU-S3			.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E				RLA-HP-C1			1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011		
0030	E				KML-TD-CC			1.00	DIA .501-1.00 REM .033-.250		.10898		.125		
0040	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0330			JA	01	15			1.00		INST/REAM SET FLANGED BUSH	.170	.026	.196		5
0010	E				RBW-BU-S1			.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.13669		.053		
0020	E				RBW-BU-B1			.50	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.137		
0030	E				RJP-PW-R1			.50	REM RPL PAPRWRK SIGN OFF DOC		.01001		.005		
9000			JA	01	00			1.00		LABOR STANDARD HISTORY	.000	.000	.000		0
0001									2 AUGUST 88 INITIAL INPUT/NEW WORKLOAD						
0010									KERRY COOP MANEL 7-3357						
0800									22 MAR 89 INITIAL INPUT MRP II						
0900									ALBERT HARWOOD MANEL 7-3733						

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 07/28/88 A-E046B-MM1-DY-M45 PAGE 0001

26338A F15 MLG L/H HW RCC MNPRA 4A4-22-3 86224

SUB STEP	TECH D	S L	S K	W #R	F A	PF C	A/R FA	REV DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY	PCT	C
RA023	S	E	JA	EA	1		J	88189	1.00	PERCENT ENGR 99.9		F-15 MAIN CONNECTING LINK	1.31		1.31			
0001			JA	01		00			.00			PART NUMBER/NSN	.000	.000	.000			0
0010										68A410611-1001		3040003291054						
0050			JA	01		15			1.00			REMOVE BUSHING 3" DIA	.087	.013	.100			8
0010	E					RBW-SU-S1			.25	S/U FOR BENCH WORK GENERAL		PRORATE OVER 4 PARTS	.27525		.079			
0020	E					RLG-RS-KB			1.00	K/O SINGLE BUSH 1-3 IN DIA		REMOVE 3" DIA BUSH/KNOCKER	.00836		.009			
0030	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011			
0055			JA	01		15			1.00			INST STRAIGHT BUSH NO POLISH	.077	.012	.089			7
0010	E					RBW-BU-S1			.25	SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS	.18669		.053			
0020	E					RBW-BU-A4			1.00	INSTALL ONE STRAIGHT BUSHING			.02062		.023			
0030	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011			
0059			JA	01		15			1.00			TURN BUSHING GROUP 1/BRONZE	.289	.043	.332			25
0010	E					RLA-SU-S3			.25	SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS	.49962		.143			
0020	E					RLA-HP-C1			2.00	1ST PART IN-OUT SCROLL CHUCK		2 BUSHINGS	.01006		.023			
0030	E					KML-TA-CC			2.00	DIA .501-1.00 REM .033-.250		2 BUSHINGS	.06699		.154			
0040	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011			
0060			JA	01		15			1.00			INST/REAM SET FLANGED BUSH	.175	.026	.202			15
0010	E					RBW-BU-S1			.25	SET UP TO REBUSH BOSSES		PRORATE OVER 4 PARTS	.18669		.053			
0020	E					RBW-BU-B1			.50	REBUSH A SET OF 2 BOSSES		INCLUDES REAM & POLISH	.23835		.137			
0030	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011			
0064			JA	01		15			1.00			TURN BUSHING GROUP 1/BRONZE	.289	.043	.332			25
0010	E					RLA-SU-S3			.25	SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS	.49962		.143			
0020	E					RLA-HP-C1			2.00	1ST PART IN-OUT SCROLL CHUCK		2 BUSHINGS	.01006		.023			
0030	E					KML-TA-CC			2.00	DIA .501-1.00 REM .033-.250		2 BUSHINGS	.06699		.154			
0040	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011			
0065			JA	01		15			1.00			TURN BUSHING GROUP 1/BRONZE	.224	.034	.259			20
0010	E					RLA-SU-S3			.25	SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS	.49962		.143			
0020	E					RLA-HP-C1			.50	1ST PART IN-OUT SCROLL CHUCK			.01006		.005			
0030	E					KML-TA-HC			1.00	DIA 4.00-5.00 REM .033-.250			.08497		.097			
0040	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011			
9000			JA	01		00			.00			LABOR STANDRD HISTORY	.000	.000	.000			0
0900										8 APR. 1988 RICHARD G. MARTIN MANEL-73357-MRPII								

TO INTERROGATE LABOR STANDARDS, INPUT

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STEP	H	S	T	K	W	R	F	A	C	PF	DC	A/R	SUPPORT ELEMENT	REV	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY	A PCT	C
A025	S	E	JA	EA	1			J		88189					1.00	PERCENT ENGR 96.6	F-15 MAIN BELL CRANK ASSY	3.38		3.38			
0001			JA	01				00							.00		PART NUMBER/NSN	.000	.000	.000			0
0010																68A410601-1001	NSL						
0030			JA	01				15							1.00		REMOVE BUSHING WITH PRESS	.089	.013	.103			3
0010	E												RBW-SU-G1		.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27525		.079			
0020	E												RLG-RS-K1		1.00	REM BUSHING (1ST OR SINGLE)		.01099		.012			
0030	E												RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0034			JA	01				15							1.00		MACHINE STD BUSHING	.289	.043	.332			10
0010	E												RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143			
0020	E												RLA-HP-C1		2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006		.023			
0030	E												KML-TA-EC		2.00	DIA 1.50-2.00 REM .033-.250		.06699		.154			
0040	E												RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0035			JA	01				15							1.00		INSTALL STD BUSHING	.077	.012	.089			3
0010	E												RBW-BU-S1		.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053			
0020	E												RBW-BU-A4		1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023			
0030	E												RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0037			JA	01				15							1.00		MACHINE CYL HOLE O/S	.622	.093	.716			21
0010	E												KMM-SU-V1		.25	S/U VERT MILL BORE SMAL FXTR	PRORATE OVER 4 PARTS	.50518		.145			
0020	E												RML-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098			
0030	E												RML-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146			
0040	E												RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087			
050	E												KMM-BA-BD		1.00	BORE HOLE 1.5 X 2 GROUP 1		.19789		.227			
060	E												RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0039			JA	01				15							1.00		MACHINE O/S BUSHING	.317	.048	.365			11
0010	E												RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143			
0020	E												RLA-HP-C1		1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011			
0030	E												KML-TD-EC		1.00	DIA 1.50-2.00 REM .033-.250		.17225		.198			
0040	E												RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0040			JA	01				15							1.00		HONE BUSHING/SUNNEN STROKER	.163	.025	.188			6
0010	E												ZHO-SU-S2		.25	SETUP SUNNEN HONE STROKER	PRORATE FOUR PARTS	.21517		.061			
0020	N														1.00		HONE BUSHING	.10000		.115			
0030	E												RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0049			JA	01				15							1.00		DRILL CROSS BOLT HOLE	.030	.005	.035			1
0010	E												RSG-JP-03		.25	PREP HAND DRILL FOR USE	PROPATED OVER 4 PARTS	.00861		.002			
0020	E												GTL-DD-A4		2.00	DRILL HOLE W/PORTABLE DRILL	DRILL CROSS BOLT HOLE 2 HOLE	.00924		.021			
0030	E												RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0050			JA	01				15							1.00		OVERSIZE HOLE WITH REAMER	.349	.052	.402			12
0010	E												RBW-BU-S1		.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053			
0020	E												RLG-HP-V7		1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078			
0030	E												RBW-BU-R2		3.00	REAM WITH LEMPCO REAMER	3 PASSES	.07337		.253			
0040	E												RBW-DB-A1		1.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.004			
0050	E												RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
0060			JA	01				15							1.00		OVERSIZE HOLE WITH REAMER	.349	.052	.402			12
0010	E												RBW-BU-S1		.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053			
0020	E												RLG-HP-V7		1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078			
0030	E												RBW-BU-R2		3.00	REAM WITH LEMPCO REAMER	3 PASSES	.07337		.253			
0040	E												RBW-DB-A1		1.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.004			
50	E												RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011			
			JA	01				15							1.00		MACHINE O/S LINK BUSHING	.373	.056	.429			1

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    0010 E          RLA-SU-S3   .25 SET UP SMALL MEDIUM LATHE   PRORATE OVER 4 PARTS          .49962          .143
    0020 E          RLA-HP-C1  2.00 1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS                  .01006          .023
    0030 E          KML-TD-CC  2.00 DIA .501-1.00 REM .033-.250                              .10898          .250
    0040 E          RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                             .01001          .011
  0070      JA 01   15         1.00                              INST/REAM SET STRAIGHT BUSH  .278  .042    .321       9
    0010 E          RBW-BU-S1   .25 SET UP TO REBUSH BOSSES     PRORATE OVER 4 PARTS         .18669          .053
    0020 E          RBW-BU-B2  1.00 REBUSH A SET OF 2 BOSSES     INCLUDES REAM & POLISH      .22231          .255
    0030 E          RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                             .01001          .011
 9000       JA 01   00          .00                              LABOR STANDRD HISTORY       .000  .000    .000       0
    0900                          8 APR. 1988  RICHARD G. MARTIN  MANEL-73357-MRPII
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TO INTERROGATE LABOR STANDARDS. INPUT

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OPER SUB STEP	TECH D	S T L	S K K	W R C	F A DC	PF FA ELEMENT	A/R REV SUPPORT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
RB001	S	E	JA	EA	3	K	86183	.56	PERCENT ENGR 99.9	GRIND REPAIR OUTER CYLINDER	3.24		1.81		
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0030									68A410702-1005	1620010760547					
0040									68A410702-1006	1620040753562					
0025			JA	01	15			.33		HONE LOWER BORE I.D.	.306	.015	.116		4
0010									HONE LOWER BORE TO MAINT						
0012									SIZE & FINISH REQ NO SUPPORT ELEMENTS AT THIS TIME						
0020	E					RTL-SU-G1		1.00	SET UP A DIAL BORE GAGE		.08248		.094		
0030	E					RGR-HM-C2		1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0040	E					RLG-IT-V4		6.00	VIS INSP INTERIOR SURFACE	BORESCOPE BEFORE & AFTER HON	.02219		.153		
0042									1 OCC PER INCH						
0050	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0026			JA	01	15			.27		HONE UPPER BORE I.D.	.306	.012	.095		3
0010									HONE UPPER BORE TO MAINT						
0012									SIZE & FINISH REQ NO SUPPORT ELEMENTS AT THIS TIME						
0020	E					RTL-SU-G1		1.00	SET UP A DIAL BORE GAGE		.08248		.094		
0030	E					RGR-HM-C2		1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0040	E					RLG-IT-V4		6.00	VIS INSP INTERIOR SURFACE	BORESCOPE BEFORE & AFTER HON	.02219		.153		
0042									1 OCC PER INCH						
0050	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
			JA	01	15			.53		1ST GRIND LOWER BORE	1.595	.127	.973		30
0010	E					RGR-SU-I2		.20	SET UP LRG INTERNAL GRINDER	PRORATE 5 PARTS	1.53372		.352		
0020	E					RGR-HP-L4		1.00	LOAD LARGE PART GAP GR FIXTR		.30830		.354		
0030	E					RLA-HP-C3		1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0040	E					KMG-ID-NE		1.00	GRIND OUT .010 4.0 ID X 3.0		.71847		.826		
0050	E					KMG-DW-ID		2.00	DRESS INTERNAL WHEEL	DRESS WHEEL AS NEEDED	.02458		.056		
0060	E					RTL-SU-G1		.50	SET UP A DIAL BORE GAGE	PRORATE 2 PARTS	.08248		.047		
0070	E					RGR-HM-C2		1.00	HANDLE & MEAS LENGTH 1 TO 5	CHECK I.D. 3 TIMES 3 PLACES	.08102		.093		
0120			JA	01	15			.05		1ST GRIND OUTBOARD TRUN-120-	.936	.007	.054		2
0010	E					RGR-SU-G1		.25	SET UP A GAP GRINDER	PRORATE 4 PARTS	1.05938		.304		
0020	E					RGR-HP-L4		1.00	LOAD LARGE PART GAP GR FIXTR		.30830		.354		
0030	E					RLA-HP-C3		1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0040	E					KMG-OD-ED		1.00	GRIND .010 2 OD X 2 1/2		.14517		.166		
0050	E					KMG-DW-OD		2.00	DRESS EXTERNAL WHEEL	1 TO SQ WHEEL 1 FOR FINISH	.02308		.053		
0060	E					RGR-HM-C2		1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0130			JA	01	15			.06		1ST GRIND POSITION COLL-130-	1.396	.013	.096		3
0010	E					RGR-SU-A1		.20	SET UP INTERNAL ATT GAP GRND	PRORATE 5 PARTS	.78266		.180		
0020	E					RGR-HP-L4		1.00	LOAD LARGE PART GAP GR FIXTR		.30830		.354		
0030	E					RLA-HP-C3		1.00	CHUCK SYMET PART IN 4 JAW	DIAL IN AXLE	.09095		.104		
0040	E					KMG-OD-LE		1.00	GRIND .010 FROM 5 IN OD X 3		.42668		.490		
0042									.015 TO .020 STOCK REMOVAL						
0050	E					RGR-WD-G2		4.00	WHEEL DRESS GAP GRINDER	DRESS WHEEL AS NEEDED	.08334		.383		
0060	E					RGR-HM-C2		1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0190			JA	01	15			.06		FINISH GRIND COLLAR OD--190-	1.498	.013	.103		3
0010	E					RGR-SU-G1		.25	SET UP A GAP GRINDER	PRORATE 4 PARTS	1.05938		.304		
0020	E					RGR-HP-L4		1.00	LOAD LARGE PART GAP GR FIXTR		.30830		.354		
0030	E					KMM-SU-A2		1.00	DIAL AXIS VERTICAL		.13083		.150		
0040	E					KMG-OD-MJ		1.00	GRIND .040 -5 1/2 OD X 2 1/2		.64451		.741		
0050	E					KMG-DW-OD		3.00	DRESS EXTERNAL WHEEL	DRESS WHEEL AS NEEDED	.02308		.079		

0060 E		RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5			.08102		.093	
	JA 01	15	.05		FINISH GRIND OUTB TRUN--210-		9.285	.070	.534	16
0010 E		RGR-SU-A1	.20	SET UP INTERNAL ATT GAP GRNDPRORATE 5 PARTS			.78266		.180	
0020 E		RGR-HP-L4	1.00	LOAD LARGE PART GAP GR FIXTR			.30830		.354	
0030 E		RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW			.09095		.104	
0040 E		KMG-ID-KK	8.00	GRIND OUT .040 4 1/2 ID X 3	24 INCH BORE		1.03946		9.563	
0050 E		RGR-WD-G2	4.00	WHEEL DRESS GAP GRINDER	DRESS WHEEL AS NEEDED		.08334		.383	
0060 E		RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5			.08102		.093	
0215	JA 01	15	.53		FINISH GRIND LOWER BORE		2.083	.166	1.270	39
0010 E		RGR-SU-I2	.20	SET UP LRG INTERNAL GRINDER	PRORATE 5 PARTS		1.53372		.352	
0020 E		RGR-HP-L4	1.00	LOAD LARGE PART GAP GR FIXTR			.30830		.354	
0030 E		RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW			.09095		.104	
0040 E		KMG-ID-LK	1.00	GRIND OUT .040 5 ID X 3	GRIND		1.15712		1.330	
0050 E		KMG-DW-ID	4.00	DRESS INTERNAL WHEEL	DRESS WHEEL AS NEEDED		.02458		.113	
0060 E		RTL-SU-G1	.50	SET UP A DIAL BORE GAGE	PRORATE 2 PARTS		.08248		.047	
0070 E		RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5	CHECK I.D. 3 TIMES 3 PLACES		.08102		.093	
0215				FINISH GRIND LOWER BORE						
9000	JA 01	15	.01		LABOR STANDARD HISTORY		.000	.000	.000	0
0010				07SEP83 REVIEW & CHG OCC. FACTORS		0.86				
0011				14NOV84 2 YR REVIEW W/OCC CHANGE > OLD STD <		1.21				
0016				19MAR85 DOWN GRADED NOT MARKET BASKET						
0900				J.CALDWELL TECH MANEAA						

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OPER SUB STEP	TECH D	S T L	S K K	W #R	F A C	PF FA DC	A/R SUPPORT ELEMENT	REV OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
RB002	S	E	JA	EA	3		K 88207	.44	PERCENT ENGR 93.4	GRIND PISTON ASSY F-15 MLG	6.42		2.82		
0001			JA	01		00		.00		PART NUMBER/NSN	.000	.000	.000		0
0030									68A410704-1011	1620018033404					
0040									68A410704-1012	1620018033407					
0050									68A410704-1005	1620018033401					
0060									68A410704-1006	1620018188799					
0070			JA	01		15		.33		1ST GRIND PISTON O.D.	3.090	.153	1.173		18
0010	N							1.00		S/U GRINDER >RGRSUG1<	1.10683		1.272		
0020	E						RGR-HP-L4	1.00	LOAD LARGE PART GAP GR FIXTR		.30830		.354		
0030	E						RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW	DIAL IN AXIS	.09095		.104		
0040	E						RGR-GE-S21	12.00	GR STEEL OD (OCC FACT L X D)	5.2 X 21.5	.01093		1.407		
0050	E						RGR-GE-D2	5.00	DWELL (GAP GRINDER STEEL OD)	5 INCH DIA	.01014		.058		
0060	E						RGR-WD-G2	2.00	WHEEL DRESS GAP GRINDER	EXTRA WHEEL DRESS AS NEEDED	.08334		.191		
0070	E						RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24		.10674		.122		
0080	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0090	E						RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0080			JA	01		15		.42		1ST GRIND M/PIN SEAL ID	1.067	.067	.515		8
0010	E						RBW-BU-P1	.20	BUTTERFLY POLISH BUSHING I D	PRORATE 5 PARTS	.00333		.000		
0020	E						RGR-HP-L4	1.00	LOAD LARGE PART GAP GR FIXTR		.30830		.354		
0030	E						RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER	DIAL IN AXIS	.02632		.030		
0040	E						KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0050	E						KMG-ID-JE	1.00	GRIND OUT .010-4 IN ID X 3	DRESS WHEEL AS NEEDED	.48265		.535		
0060	E						KMG-DW-ID	1.00	DRESS INTERNAL WHEEL	PRORATE 2 PARTS	.02458		.028		
0070	E						RGR-GE-D2	1.00	DWELL (GAP GRINDER STEEL OD)	CHECK I.D. 3 TIMES 3 PLACES	.01014		.011		
0080	E						RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090	E						ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.		
0100	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		..		
0082			JA	01		15		.58		1ST GRIND INNER AXLE JRNL	1.197	.104	.798		12
0010	E						RGR-SU-G1	.50	SET UP A GAP GRINDER	PRORATE W/SUB OP 0027	1.05938		.609		
0020	E						RGR-HP-L4	.50	LOAD LARGE PART GAP GR FIXTR	PRORATE W/SUB OP 0027	.30830		.177		
0030	E						RLA-HP-C3	.50	CHUCK SYMET PART IN 4 JAW	PRORATE W/SUB OP 0027	.09095		.052		
0040	E						KMG-OD-GE	1.00	GRIND .010 3 OD X 3		.25700		.295		
0050	E						RGR-GE-D2	1.00	DWELL (GAP GRINDER STEEL OD)		.01014		.011		
0060	E						RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER		.08334		.095		
0070	E						RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0080	E						RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0085			JA	01		15		.58		1ST GRIND OUTER AXLE JRNL	1.197	.104	.798		12
0010	E						RGR-SU-G1	.50	SET UP A GAP GRINDER	PRORATE W/SUB OP 0025	1.05938		.609		
0020	E						RGR-HP-L4	.50	LOAD LARGE PART GAP GR FIXTR	PRORATE W/SUB OP 0025	.30830		.177		
0030	E						RLA-HP-C3	.50	CHUCK SYMET PART IN 4 JAW	PRORATE W/SUB OP 0025	.09095		.052		
0040	E						KMG-OD-GE	1.00	GRIND .010 3 OD X 3		.25700		.295		
0050	E						RGR-GE-D2	1.00	DWELL (GAP GRINDER STEEL OD)		.01014		.011		
0060	E						RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER		.08334		.095		
0070	E						RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0080	E						RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
			JA	01		15		.17		FINISH GRIND PISTON O.D	4.408	.112	.862		13
0010	E						RGR-SU-G1	1.00	SET UP A GAP GRINDER		1.05938		1.218		

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    0020 E          RGR-HP-L4  1.00 LOAD LARGE PART GAP GR FIXTR                                .30830          .354
    0030 E          RLA-HP-C3  1.00 CHUCK SYMET PART IN 4 JAW                                   .09095          .104
    0040 E          RGR-GE-C21 12.00 GR CHROM OD (OCC FACT L X D)5.2 X 21.5                     .02189          2.819
    0050 E          RGR-GE-D3   5.20 DWELL (GAP GRINDER CHROM OD)5.2 INCH DIA                   .02029          .121
    0060 E          RGR-WD-G2   3.00 WHEEL DRESS GAP GRINDER     DRESS WHEEL AS NEEDED          .08334          .287
    0070 E          RGR-HM-C4   1.00 HANDLE & MEAS LENGTH 12 - 24                               .10674          .122
    0080 E          RJP-PW-R1   1.00 REM RPL PAPRWRK SIGN OFF DOC                               .01001          .011
    0090 E          RGR-HM-T2   1.00 ADJUST TAPER - GAP GRINDER                                 .02632          .030
0170        JA 01   15           .17                            FINISH GRIND M/PIN SEAL      1.801   .046    .352        5
    0010 E          RGR-SU-I2    .20 SET UP LRG INTERNAL GRINDER PRORATE 5 PARTS               1.53372         .352
    0020 E          RGR-HP-L4   1.00 LOAD LARGE PART GAP GR FIXTR                             .30830          .354
    0030 E          RLA-HP-C3   1.00 CHUCK SYMET PART IN 4 JAW                                .09095          .104
    0040 E          RGR-HM-T2   1.00 ADJUST TAPER - GAP GRINDER                               .02632          .030
    0050 E          KMG-DW-ID   1.00 DRESS INTERNAL WHEEL       DRESS WHEEL AS NEEDED         .02458          .028
    0060 E          KMG-GW-LK   1.00 LOCATE WHEEL TO POSITION   PRORATE 2 PARTS               .06761          .077
    0070 E          KMG-ID-MK   1.00 GRIND OUT .040-3.5 ID X 3  CHECK I.D. 3 TIMES 3 PLACES   .80697          .928
    0080 E          RGR-GE-D3   1.00 DWELL (GAP GRINDER CHROM OD)                             .02029          .023
    0090 E          RGR-HM-C2   1.00 HANDLE & MEAS LENGTH 1 TO 5                              .08102          .073
    0100 E          ZIT-VI-B2   1.00 VISUAL INSP MEDIUM CYL I.D.                              .05578          .064
    0110 E          RBW-BU-P1   1.00 BUTTERFLY POLISH BUSHING I D                             .00333          .003
    0120 E          RJP-PW-R1   1.00 REM RPL PAPRWRK SIGN OFF DOC                             .01001          .011
0175        JA 01   15           .58                            GRIND CHROME                 1.788   .156    1.193       19
    0010 E          RGR-SU-G1   1.00 SET UP A GAP GRINDER       PRORATE OVER 4 PARTS         1.05938         1.218
    0020 E          RLA-HP-C3   1.00 CHUCK SYMET PART IN 4 JAW                               .09095          .104
    0030 E          RGR-HM-T2   1.00 ADJUST TAPER - GAP GRINDER                              .02632          .030
    0040 E          KMG-DW-OD   1.00 DRESS EXTERNAL WHEEL                                    .02308          .026
    0050 E          KMG-GW-LK   1.00 LOCATE WHEEL TO POSITION                                .06761          .077
    0060 E          KMG-OD-GK   1.00 GRIND .040  3 OD X 3                                   .41367          .475
    0070 E          RGR-GE-D3   3.00 DWELL (GAP GRINDER CHROM OD)OCCURRANCED FOR DIA          .02029          .070
    0080 E          RTL-MM-M3   6.00 MIC O D FIRST MEASUREMENT  2 PLACES 3 CHECKS EACH        .00616          .042
    0090 E          RJP-PW-R1   1.00 REM RPL PAPRWRK SIGN OFF DOC                             .01001          .011
0177        JA 01   15           .64                            GRIND CHROME                 .994    .095    .732        11
    0010 E          RGR-SU-G1    .25 SET UP A GAP GRINDER       PRORATE OVER 4 PARTS         1.05938         .304
    0020 E          RLA-HP-C3   1.00 CHUCK SYMET PART IN 4 JAW                               .09095          .104
    0030 E          RGR-HM-T2   1.00 ADJUST TAPER - GAP GRINDER                              .02632          .030
    0040 E          KMG-DW-OD   1.00 DRESS EXTERNAL WHEEL                                    .02308          .026
    0050 E          KMG-GW-LK   1.00 LOCATE WHEEL TO POSITION                                .06761          .077
    0060 E          KMG-OD-GK   1.00 GRIND .040  3 OD X 3                                   .41367          .475
    0070 E          RGR-GE-D3   3.00 DWELL (GAP GRINDER CHROM OD)OCCURRANCED FOR DIA          .02029          .070
    0080 E          RTL-MM-M3   6.00 MIC O D FIRST MEASUREMENT  2 PLACES 3 CHECKS EACH        .00616          .042
    0090 E          RJP-PW-R1   1.00 REM RPL PAPRWRK SIGN OFF DOC                             .01001          .011
9000        JA 01   15           .01                            LABOR STANDARD HISTORY       .000    .000    .000        0
    0010                        13SEP83 NEW INPUT-NO OCC FACTOR ON SUB OP'S 0025 &
    0020                              0027, 0050 & 0060  <OLD STD>          .58
    0021                        14NOV84 2 YR REVIEW W/OCC CHANGE > OLD STD <   .72
    0026                        18MAR85 DOWN GRADED NOT MARKET BASKET
    0900                         J.CALDWELL TECH MANEAA


TO INTERROGATE LABOR STANDARDS, INPUT

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26338A F15 MLG L/H HW RCC MNPRB 4A4-22-3 86224

SUB STEP	TECH	S	S	W	F	PF	A/R	REV	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
RB004	S	E	JA	EA	3		J	88187	.05	PERCENT ENGR 99.9	GRIND TORQUE ARM	2.59		.12	
0001			JA	01		00			.00		PART NUMBER/NSN	.000	.000	.000	0
0010										68A410646-2005	1620001386306				
C080			JA	01		15			.25		JIG GRINDER LABOR	1.151	.043	.331	13
0010	E					RGR-SU-J1			.25	S/U JIG GRINDER SML FIXTURE	PRORATE OVER 4 PARTS	.75732		.217	
0020	E					KMM-HP-CB			1.00	HAND HANDLE WRAPPED 2 CLAMPS		.09202		.105	
0030	E					RML-AL-BB			1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137	
0040	E					RML-AL-AC			1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E					KMG-DW-OD			3.00	DRESS EXTERNAL WHEEL	3 DRESSES REQUIRED	.02458		.084	
0060	E					KMG-GW-LK			3.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.233	
0070	E					KMG-OD-HE			1.00	GRIND .010 3 1/2 OD X 3		.30050		.345	
0080	E					RGR-HM-C2			1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0090	E					RTL-MM-M3			1.00	MIC O D FIRST MEASUREMENT		.00616		.007	
0100	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0090			JA	01		15			.25		JIG GRINDER LABOR	.878	.033	.253	10
0010	E					RGR-SU-J1			.25	S/U JIG GRINDER SML FIXTURE	PRORATE OVER 4 PARTS	.75732		.217	
0020	E					KMM-HP-CB			1.00	HAND HANDLE WRAPPED 2 CLAMPS		.09202		.105	
0030	E					RML-AL-BB			1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137	
0040	E					RML-AL-AC			1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E					KMG-DW-OD			3.00	DRESS EXTERNAL WHEEL	3 DRESSES REQUIRED	.02308		.079	
0060	E					KMG-GW-LK			3.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.233	
0070	E					KMG-OD-CA			1.00	GRIND .010 1 OD X 1		.03200		.036	
0080	E					RGR-HM-C2			1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0090	E					RTL-MM-M3			1.00	MIC O D FIRST MEASUREMENT		.00616		.007	
0100	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0100			JA	01		15			.25		JIG GRINDER LABOR	.993	.037	.286	11
0010	E					RGR-SU-J1			.25	S/U JIG GRINDER SML FIXTURE	PRORATE OVER 4 PARTS	.75732		.217	
0020	E					KMM-HP-CB			1.00	HAND HANDLE WRAPPED 2 CLAMPS		.09202		.105	
0030	E					RML-AL-BB			1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137	
0040	E					RML-AL-AC			1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E					KMG-DW-ID			3.00	DRESS INTERNAL WHEEL	3 DRESSES REQUIRED	.02458		.084	
0060	E					KMG-GW-LK			3.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.233	
0070	E					KMG-ID-EB			1.00	GRIND OUT .010 2.00 ID X 1.0		.09266		.106	
0080	E					RGR-HM-C2			1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0090	E					ZIT-VI-B2			1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.064	
0100	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0110			JA	01		15			.25		JIG GRINDER LABOR	.993	.037	.286	11
0010	E					RGR-SU-J1			.25	S/U JIG GRINDER SML FIXTURE	PRORATE OVER 4 PARTS	.75732		.217	
0020	E					KMM-HP-CB			1.00	HAND HANDLE WRAPPED 2 CLAMPS		.09202		.105	
0030	E					RML-AL-BB			1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137	
0040	E					RML-AL-AC			1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E					KMG-DW-ID			3.00	DRESS INTERNAL WHEEL	3 DRESSES REQUIRED	.02458		.084	
0060	E					KMG-GW-LK			3.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.233	
0070	E					KMG-ID-EB			1.00	GRIND OUT .010 2.00 ID X 1.0		.09266		.106	
0080	E					RGR-HM-C2			1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093	
0090	E					ZIT-VI-B2			1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.064	
0100	E					RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
			JA	01		15			.25		JIG GRINDER LABOR	1.777	.067	.511	20
0010	E					RGR-SU-J1			.25	S/U JIG GRINDER SML FIXTURE	PRORATE OVER 4 PARTS	.75732		.217	

0020 E		KMM-HP-CB	1.00	HAND HANDLE WRAPPED 2 CLAMPS		.09202		.105		
0030 E		RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137		
40 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
50 E		KMG-DW-OD	3.00	DRESS EXTERNAL WHEEL	3 DRESSES REQUIRED	.02308		.079		
0060 E		KMG-GW-LK	3.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.233		
0070 E		KMG-ID-HK	1.00	GRIND OUT .040-3.5 ID X 3		.80697		.928		
0080 E		RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090 E		KMG-OD-FF	1.00	GRIND .040 2 1/2 OD X 1		.13000		.149		
0100 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0220	JA 01	15	.25		JIG GRINDER LABOR	.898	.034	.258		10
0010 E		RGR-SU-J1	.25	S/U JIG GRINDER SML FIXTURE	PRORATE OVER 4 PARTS	.75732		.217		
0020 E		KMM-HP-CB	1.00	HAND HANDLE WRAPPED 2 CLAMPS		.09202		.105		
0030 E		RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137		
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050 E		KMG-DW-OD	3.00	DRESS EXTERNAL WHEEL	3 DRESSES REQUIRED	.02308		.079		
0060 E		KMG-GW-LK	3.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.233		
0070 E		KMG-OD-CF	1.00	GRIND .040 1 OD X 1		.05200		.059		
0080 E		RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090 E		RTL-MM-M3	1.00	MIC O D FIRST MEASUREMENT		.00616		.007		
0100 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0230	JA 01	15	.25		JIG GRINDER LABOR	1.091	.041	.314		12
0010 E		RGR-SU-J1	.25	S/U JIG GRINDER SML FIXTURE	PRORATE OVER 4 PARTS	.75732		.217		
0020 E		KMM-HP-CB	1.00	HAND HANDLE WRAPPED 2 CLAMPS		.09202		.105		
0030 E		RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137		
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050 E		KMG-DW-ID	3.00	DRESS INTERNAL WHEEL	3 DRESSES REQUIRED	.02458		.084		
0060 E		KMG-GW-LK	3.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.233		
0070 E		KMG-ID-EG	1.00	GRIND OUT .040 2 ID X 1		.19049		.219		
080 E		RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090 E		ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.064		
0100 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0240	JA 01	15	.25		JIG GRINDER LABOR	1.241	.047	.357		14
0010 E		RGR-SU-J1	.25	S/U JIG GRINDER SML FIXTURE	PRORATE OVER 4 PARTS	.75732		.217		
0020 E		KMM-HP-CB	1.00	HAND HANDLE WRAPPED 2 CLAMPS		.09202		.105		
0030 E		RML-AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137		
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050 E		KMG-DW-ID	3.00	DRESS INTERNAL WHEEL	3 DRESSES REQUIRED	.02458		.084		
0060 E		KMG-GW-LK	3.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.233		
0070 E		KMG-ID-EJ	1.00	GRIND OUT .040 2 ID X 2		.34082		.391		
0080 E		RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090 E		ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.064		
0100 E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000	JA 01	15	.01		LABOR STANDARD HISTORY	.000	.000	.000		0
0010				21NOV85 INITAL INPUT NEW REPAIR						
0900				J.C.ALDWELL TECH MANEAA						

TO INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 07/28/88 A-E0468-MM1-DY-M45 PAGE 0001

26338A F15 MLG L/H HW RCC MNPRB 4A4-22-3 86224

SUB STEP	TECH D	S L	S K	WR C	A DC	FA ELEMENT	SUPPORT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
RB006	S	N	JA	EA	3	J	88188	.05	PERCENT ENGR 75.9	GRIND APEX PIN-JURY LINK	1.40		.07		
0001			JA	01		00		.00		PART NUMBER/NSN	.000	.000	.000		0
0010									68A410764-2001	5315005546340					
0050			JA	01		15		1.00		1ST GRIND O.D.	.588	.08S	.677		48
0010	E				RGR	SU	C2	1.00	SET UP SMALL MED CYL GRINDER		.29197		.335		
0020	E				RLA	HP	C6	1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028		
0030	E				RGR	HM	T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG	DW	OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E				KMG	GW	LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG	OD	BD	1.00	GRIND .010 3/4D X 2 1/2 L		.05417		.062		
0070	E				RGR	GE	D2	1.00	DWELL (GAP GRINDER STEEL OD)		.01014		.011		
0080	E				RGR	HM	C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0120			JA	01		15		1.00		FINISH GRIND O.D.	.635	.095	.731		52
0010	N							1.00		S/U GRINDER > RGRSUC2 <	.29500		.339		
0020	E				RLA	HP	C6	1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028		
0030	E				RGR	HM	T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG	DW	OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E				KMG	GW	LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG	OD	BJ	1.00	GRIND .040 3/4 OD X 2 1/2		.08734		.100		
0070	E				RGR	GF	D3	1.00	DWELL (GAP GRINDER CHROM OD)		.02029		.023		
0080	E				RGR	HM	C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000			JA	01		15		.01		LABOR STANDARD HISTORY	.000	.000	.000		0
0010									13SEP83 NEW INPUT-NO OCC FACTOR HISTORY						
0011									14NOV84 2 YR REVIEW W/OCC CHANGE > OLD STD < .13						
0016									18MAR85 DOWN GRADED NOT MARKET BASKET						
0900									J.CALDWELL TECH MANEAA						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR
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OPER SUB STEP	TECH D	S L	S K	W $R	F A	PF C	A/R DC	REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
R5007	S	E	JA	EA	3		K	88190	.11	PERCENT ENGR 99.9	GRIND TRUNNION PIN	2.35		.25		
0001			JA	01			15		.00		PART NUMBER/ NSN	.000	.000	.000		0
0010										68A410735-2001	1620003386529					
0060			JA	01			15		1.00		1ST GRIND O.D.	.489	.073	.563		24
0010	E			RGR-SU-C2					.25	SET UP SMALL MED CYL GRINDERPRORATE OVER 4 PARTS		.29197		.083		
0020	E			RLA-HP-C3					1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E			RGR-HM-T2					1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E			KMG-DW-OD					2.00	DRESS EXTERNAL WHEEL		.02308		.053		
0050	E			KMG-GW-LK					1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E			KMG-OD-EC					1.00	GRIND .010 2 OD X 2		.11834		.136		
0070	E			RGR-GE-D2					2.00	DWELL (GAP GRINDER STEEL OD)OCCURRANCED FOR DIA		.01014		.023		
0080	E			RTL-MM-M3					6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042		
0090	E			RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0070			JA	01			15		1.00		1ST GRIND O.D.	.455	.068	.523		22
0010	E			RGR-SU-C2					.25	SET UP SMALL MED CYL GRINDERPRORATE OVER 4 PARTS		.29197		.083		
0020	E			RLA-HP-C3					1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E			RGR-HM-T2					1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E			KMG-DW-OD					2.00	DRESS EXTERNAL WHEEL		.02308		.053		
0050	E			KMG-GW-LK					1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E			KMG-OD-DC					1.00	GRIND .010 1 1/2 OD X 2		.08884		.102		
0070	E			RGR-GE-D2					1.50	DWELL (GAP GRINDER STEEL OD)OCCURRANCED FOR DIA		.01014		.017		
0080	E			RTL-MM-M3					6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042		
0090	E			RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0150			JA	01			15		1.00		GRIND CHROME	.582	.087	.670		28
0010	E			RGR-SU-C2					.25	SET UP SMALL MED CYL GRINDERPRORATE OVER 4 PARTS		.29197		.083		
0020	E			RLA-HP-C3					1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E			RGR-HM-T2					1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E			KMG-DW-OD					2.00	DRESS EXTERNAL WHEEL		.02308		.053		
0050	E			KMG-GW-LK					1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E			KMG-OD-EH					1.00	GRIND .040 2 OD X 2		.19084		.219		
0070	E			RGR-GE-D3					2.00	DWELL (GAP GRINDER CHROM OD)OCCURRANCED FOR DIA		.02029		.046		
0080	E			RTL-MM-M3					6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042		
0090	E			RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0160			JA	01			15		1.00		CHROME GRIND O.D.	.524	.079	.603		26
0010	E			RGR-SU-C2					.25	SET UP SMALL MED CYL GRINDERPRORATE OVER 4 PARTS		.29197		.083		
0020	E			RLA-HP-C3					1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E			RGR-HM-T2					1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E			KMG-DW-OD					2.00	DRESS EXTERNAL WHEEL		.02308		.053		
0050	E			KMG-GW-LK					1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E			KMG-OD-DH					1.00	GRIND .040 1 1/2 OD X 2		.14334		.164		
0070	E			RGR-GE-D3					1.50	DWELL (GAP GRINDER CHROM OD)OCCURRANCED FOR DIA		.02029		.035		
0080	E			RTL-MM-M3					6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042		
0090	E			RJP-PW-R1					1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000			JA	01			15		.01		LABOR STANDARD HISTORY	.000	.000	.000		0
0010										07SEP83 REVIEW & CHG OCC. FACTORS 0.19						
0011										14NOV84 2 YR REVIEW W/OCC CHANGE > OLD STD < .10						
0016										18MAR85 DOWN GRADED NOT MARKET BASKET						
0900										J.CALDWELL TECH MANEMA						

0020	E		RGR-HP-L4	1.00	LOAD LARGE PART GAP GR FIXTR			.30830		.354	
0030	E		RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW	DIAL IN CYL O.D.		.09095		.104	
0040	E		RGR-GE-C21	12.00	GR CHROM OD (OCC FACT L X D)	5.2 X 21.5		.02189		2.819	
0050	E		RGR-GE-D3	5.20	DWELL (GAP GRINDER CHROM OD)	5.2 INCH DIA		.02029		.121	
0060	E		RGR-WD-G2	3.00	WHEEL DRESS GAP GRINDER	DRESS WHEEL AS NEEDED		.08334		.287	
0070	E		RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24			.10674		.122	
0080	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0090	E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER			.02632		.030	
0170		JA 01	15	.17		FINISH GRIND M/PIN SEAL		1.801	.046	.352	5
0010	E		RGR-SU-I2	.20	SET UP LRG INTERNAL GRINDER	PRORATE 5 PARTS		1.53372		.352	
0020	E		RGR-HP-L4	1.00	LOAD LARGE PART GAP GR FIXTR			.30830		.354	
0030	E		RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW			.09095		.104	
0040	E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER			.02632		.030	
0050	E		KMG-DW-ID	1.00	DRESS INTERNAL WHEEL	DRESS WHEEL AS NEEDED		.02458		.028	
0060	E		KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION	PRORATE 2 PARTS		.06761		.077	
0070	E		KMG-ID-HK	1.00	GRIND OUT .040-3.5 ID X 3	CHECK I.D. 3 TIMES 3 PLACES		.80697		.928	
0080	E		RGR-GE-D3	1.00	DWELL (GAP GRINDER CHROM OD)			.02029		.023	
0090	E		RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5			.08102		.093	
0100	E		ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.			.05578		.064	
0110	E		RBW-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D			.00333		.003	
0120	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0175		JA 01	15	.58		GRIND CHROME		1.788	.156	1.193	19
0010	E		RGR-SU-G1	1.00	SET UP A GAP GRINDER	PRORATE OVER 4 PARTS		1.05938		1.218	
0020	E		RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW			.09095		.104	
0030	E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER			.02632		.030	
0040	E		KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL			.02308		.026	
0050	E		KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION			.06761		.077	
0060	E		KMG-OD-GK	1.00	GRIND .040 3 OD X 3			.41367		.475	
0070	E		RGR-GE-D3	3.00	DWELL (GAP GRINDER CHROM OD)	OCCURRANCES FOR DIA		.02029		.070	
0080	E		RTL-MM-M3	6.00	MIC O D FIRST MEASUREMENT	2 PLACES 3 CHECKS EACH		.00616		.042	
0090	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0177		JA 01	15	.64		GRIND CHROME		.994	.095	.732	11
0010	E		RGR-SU-G1	.25	SET UP A GAP GRINDER	PRORATE OVER 4 PARTS		1.05938		.304	
0020	E		RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW			.09095		.104	
0030	E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER			.02632		.030	
0040	E		KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL			.02308		.026	
0050	E		KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION			.06761		.077	
0060	E		KMG-OD-GK	1.00	GRIND .040 3 OD X 3			.41367		.475	
0070	E		RGR-GE-D3	3.00	DWELL (GAP GRINDER CHROM OD)	OCCURRANCES FOR DIA		.02029		.070	
0080	E		RTL-MM-M3	6.00	MIC O D FIRST MEASUREMENT	2 PLACES 3 CHECKS EACH		.00616		.042	
0090	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
9000		JA 01	15	.01		LABOR STANDARD HISTORY		.000	.000	.000	0
0010					13SEP83 NEW INPUT-ND OCC FACTOR ON SUB OP'S 0025 &						
0020					0027, 0050 & 0060 <OLD STD>	.58					
0021					14NOV84 2 YR REVIEW W/OCC CHANGE > OLD STD <	.72					
0026					18MAR85 DOWN GRADED NOT MARKET BASKET						
0900					J.CALDWELL TECH MANEAA						

TO INTERROGATE LABOR STANDARDS, INPUT

"RD NROP NR
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SUB STEP	TECH D	S L	S W #R K	F A C	PF FA DC	A/R SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY	A PCT C
RR004	S	E	JA EA	3	J	88187	.05	PERCENT ENGR 99.9	GRIND TORQUE ARM	2.59		.12		
0001			JA 01		00		.00		PART NUMBER/NSN	.000	.000	.000		0
0010								68A410646-2005	1620001386306					
0080			JA 01		15		.25		JIG GRINDER LABOR	1.151	.043	.331		13
0010	E				RGR	SU-J1	.25	S/U JIG GRINDER SML FIXTURE	PRORATE OVER 4 PARTS	.75732		.217		
0020	E				KMM	HP-CB	1.00	HAND HANDLE WRAPPED 2 CLAMPS		.09202		.105		
0030	E				RML	AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137		
0040	E				RML	AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E				KMG	DW-OD	3.00	DRESS EXTERNAL WHEEL	3 DRESSES REQUIRED	.02458		.084		
0060	E				KMG	GW-LK	3.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.233		
0070	E				KMG	OD-HE	1.00	GRIND .010 3 1/2 OD X 3		.30050		.345		
0080	E				RGR	HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090	E				RTL	MM-M3	1.00	MIC O D FIRST MEASUREMENT		.00616		.007		
0100	E				RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0090			JA 01		15		.25		JIG GRINDER LABOR	.878	.033	.253		10
0010	E				RGR	SU-J1	.25	S/U JIG GRINDER SML FIXTURE	PRORATE OVER 4 PARTS	.75732		.217		
0020	E				KMM	HP-CB	1.00	HAND HANDLE WRAPPED 2 CLAMPS		.09202		.105		
0030	E				RML	AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137		
0040	E				RML	AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E				KMG	DW-OD	3.00	DRESS EXTERNAL WHEEL	3 DRESSES REQUIRED	.02308		.079		
0060	E				KMG	GW-LK	3.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.233		
0070	E				KMG	OD-CA	1.00	GRIND .010 1 OD X 1		.03200		.036		
0080	E				RGR	HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090	E				RTL	MM-M3	1.00	MIC O D FIRST MEASUREMENT		.00616		.007		
0100	E				RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0100			JA 01		15		.25		JIG GRINDER LABOR	.993	.037	.286		11
0010	E				RGR	SU-J1	.25	S/U JIG GRINDER SML FIXTURE	PRORATE OVER 4 PARTS	.75732		.217		
0020	E				KMM	HP-CB	1.00	HAND HANDLE WRAPPED 2 CLAMPS		.09202		.105		
0030	E				RML	AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137		
0040	E				RML	AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E				KMG	DW-ID	3.00	DRESS INTERNAL WHEEL	3 DRESSES REQUIRED	.02458		.084		
0060	E				KMG	GW-LK	3.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.233		
0070	E				KMG	ID-EB	1.00	GRIND OUT .010 2.00 ID X 1.0		.09266		.106		
0080	E				RGR	HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090	E				ZIT	VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.064		
0100	E				RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0110			JA 01		15		.25		JIG GRINDER LABOR	.993	.037	.286		11
0010	E				RGR	SU-J1	.25	S/U JIG GRINDER SML FIXTURE	PRORATE OVER 4 PARTS	.75732		.217		
0020	E				KMM	HP-CB	1.00	HAND HANDLE WRAPPED 2 CLAMPS		.09202		.105		
0030	E				RML	AL-BB	1.00	ALIGN VERTICAL AXIS CLAMP		.11975		.137		
0040	E				RML	AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E				KMG	DW-ID	3.00	DRESS INTERNAL WHEEL	3 DRESSES REQUIRED	.02458		.084		
0060	E				KMG	GW-LK	3.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.233		
0070	E				KMG	ID-EB	1.00	GRIND OUT .010 2.00 ID X 1.0		.09266		.106		
0080	E				RGR	HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090	E				ZIT	VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.064		
0100	E				RJP	PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
			JA 01		15		.25		JIG GRINDER LABOR	1.777	.067	.511		20
0010	E				RGR	SU-J1	.25	S/U JIG GRINDER SML FIXTURE	PRORATE OVER 4 PARTS	.75732		.217		

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    0020 E        KMM-HP-CB  1.00 HAND HANDLE WRAPPED 2 CLAMPS                                  .09202          .105
    0030 E        RML-AL-BB  1.00 ALIGN VERTICAL AXIS CLAMP                                     .11975          .137
    0040 E        RML-AL-AC  1.00 ALIGN HOLE TO SPINDLE ROD                                     .07609          .087
    0050 E        KMG-DW-OD  3.00 DRESS EXTERNAL WHEEL        3 DRESSES REQUIRED                .02308          .079
    0060 E        KMG-GW-LK  3.00 LOCATE WHEEL TO POSITION    LOCATE AFTER EACH DRESS           .06761          .233
    0070 E        KMG-ID-HK  1.00 GRIND OUT .040-3.5 ID X 3                                     .80697          .928
    0080 E        RGR-HM-C2  1.00 HANDLE & MEAS LENGTH 1 TO 5                                   .08102          .093
    0090 E        KMG-OD-FF  1.00 GRIND .040  2 1/2 OD X 1                                      .13000          .149
    0100 E        RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                                  .01001          .011
  0220      JA 01  15          .25                                JIG GRINDER LABOR             .898   .034     .258      10
    0010 E        RGR-SU-J1   .25 S/U JIG GRINDER SML FIXTURE PRORATE OVER 4 PARTS              .75732          .217
    0020 E        KMM-HP-CB  1.00 HAND HANDLE WRAPPED 2 CLAMPS                                  .09202          .105
    0030 E        RML-AL-BB  1.00 ALIGN VERTICAL AXIS CLAMP                                     .11975          .137
    0040 E        RML-AL-AC  1.00 ALIGN HOLE TO SPINDLE ROD                                     .07609          .087
    0050 E        KMG-DW-OD  3.00 DRESS EXTERNAL WHEEL        3 DRESSES REQUIRED                .02308          .079
    0060 E        KMG-GW-LK  3.00 LOCATE WHEEL TO POSITION    LOCATE AFTER EACH DRESS           .06761          .233
    0070 E        KMG-OD-CF  1.00 GRIND .040  1 OD X 1                                          .05200          .059
    0080 E        RGR-HM-C2  1.00 HANDLE & MEAS LENGTH 1 TO 5                                   .08102          .093
    0090 E        RTL-MM-M3  1.00 MIC O D FIRST MEASUREMENT                                     .00616          .007
    0100 E        RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                                  .01001          .011
  0230      JA 01  15          .25                                JIG GRINDER LABOR            1.091   .041     .314      12
    0010 E        RGR-SU-J1   .25 S/U JIG GRINDER SML FIXTURE PRORATE OVER 4 PARTS              .75732          .217
    0020 E        KMM-HP-CB  1.00 HAND HANDLE WRAPPED 2 CLAMPS                                  .09202          .105
    0030 E        RML-AL-BB  1.00 ALIGN VERTICAL AXIS CLAMP                                     .11975          .137
    0040 E        RML-AL-AC  1.00 ALIGN HOLE TO SPINDLE ROD                                     .07609          .087
    0050 E        KMG-DW-ID  3.00 DRESS INTERNAL WHEEL        3 DRESSES REQUIRED                .02458          .084
    0060 E        KMG-GW-LK  3.00 LOCATE WHEEL TO POSITION    LOCATE AFTER EACH DRESS           .06761          .233
    0070 E        KMG-ID-EG  1.00 GRIND OUT .040  2 ID X 1                                      .19049          .219
    0080 E        RGR-HM-C2  1.00 HANDLE & MEAS LENGTH 1 TO 5                                   .08102          .093
    0090 E        ZIT-VI-B2  1.00 VISUAL INSP MEDIUM CYL I.D.                                   .05578          .064
    0100 E        RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                                  .01001          .011
  0240      JA 01  15          .25                                JIG GRINDER LABOR            1.241   .047     .357      14
    0010 E        RGR-SU-J1   .25 S/U JIG GRINDER SML FIXTURE PRORATE OVER 4 PARTS              .75732          .217
    0020 E        KMM-HP-CB  1.00 HAND HANDLE WRAPPED 2 CLAMPS                                  .09202          .105
    0030 E        RML-AL-BB  1.00 ALIGN VERTICAL AXIS CLAMP                                     .11975          .137
    0040 E        RML-AL-AC  1.00 ALIGN HOLE TO SPINDLE ROD                                     .07609          .087
    0050 E        KMG-DW-ID  3.00 DRESS INTERNAL WHEEL        3 DRESSES REQUIRED                .02458          .084
    0060 E        KMG-GW-LK  3.00 LOCATE WHEEL TO POSITION    LOCATE AFTER EACH DRESS           .06761          .233
    0070 E        KMG-ID-EJ  1.00 GRIND OUT .040  2 ID X 2                                      .34082          .391
    0080 E        RGR-HM-C2  1.00 HANDLE & MEAS LENGTH 1 TO 5                                   .08102          .093
    0090 E        ZIT-VI-B2  1.00 VISUAL INSP MEDIUM CYL I.D.                                   .05578          .064
    0100 E        RJP-PW-R1  1.00 REM RPL PAPRWRK SIGN OFF DOC                                  .01001          .011
  9000      JA 01  15          .01                                LABOR STANDARD HISTORY        .000   .000     .000       0
      0010                      21NOV85 INITAL INPUT NEW REPAIR
      0900                      J.CALDWELL TECH MANEAA


TO INTERROGATE LABOR STANDARDS, INPUT

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OPER SUB STEP	TECH D	S L	S K	W #R	F A C	PF FA DC	A/R SUPPORT ELEMENT	REV OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT	C
RB009	S	E	JA	EA	3	K	88190	.05	PERCENT ENGR 99.9	GRIND JURY LINK PIN F-15M	2.24		.11		
0001			JA	01		00		.00		PART NUMBER/NSN	.000	.000	.000		0
0010									68A410756-1001	1620003386530					
0050			JA	01		15		1.00		1ST GRIND O.D.	.419	.063	.483		21
0010	E				RGR-SU-C2			.25	SET UP SMALL MED CYL GRINDERPRORATE OVER 4 PARTS		.29197		.083		
0020	E				RLA-HP-C3			1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E				RGR-HM-T2			1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG-DW-OD			2.00	DRESS EXTERNAL WHEEL		.02308		.053		
0050	E				KMG-GW-LK			1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG-OD-CC			1.00	GRIND 010 1 OD X 2		.05867		.067		
0070	E				RGR-GE-D2			1.00	DWELL (GAP GRINDER STEEL OD)OCCURRANCED FOR DIA		.01014		.011		
0080	E				RTL-MM-M3			6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042		
0090	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0055			JA	01		15		1.00		1ST GRIND O.D.	.455	.068	.523		23
0010	E				RGR-SU-C2			.25	SET UP SMALL MED CYL GRINDERPRORATE OVER 4 PARTS		.29197		.083		
0020	E				RLA-HP-C3			1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E				RGR-HM-T2			1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG-DW-OD			2.00	DRESS EXTERNAL WHEEL		.02308		.053		
0050	E				KMG-GW-LK			1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG-OD-DC			1.00	GRIND .010 1 1/2 OD X 2		.08884		.102		
0070	E				RGR-GE-D2			1.50	DWELL (GAP GRINDER STEEL OD)OCCURRANCED FOR DIA		.01014		.017		
0080	E				RTL-MM-M3			6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042		
0090	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0120			JA	01		15		1.00		GRIND CHROME O. D.	.554	.083	.637		28
0010	E				RGR-SU-C2			.25	SET UP SMALL MED CYL GRINDERPRORATE OVER 4 PARTS		.29197		.083		
0020	E				RLA-HP-C3			2.00	CHUCK SYMET PART IN 4 JAW		.09095		.209		
0030	E				RGR-HM-T2			1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG-DW-OD			1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E				KMG-GW-LK			1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG-OD-CH			1.00	GRIND .040 1 OD X 2		.09467		.108		
0070	E				RGR-GE-D3			2.00	DWELL (GAP GRINDER CHROM OD)OCCURRANCED FOR DIA		.02029		.046		
0080	E				RTL-MM-M3			6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042		
0090	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0125			JA	01		15		1.00		CHROME GRIND O.D.	.524	.079	.603		27
0010	E				RGR-SU-C2			.25	SET UP SMALL MED CYL GRINDERPRORATE OVER 4 PARTS		.29197		.083		
0020	E				RLA-HP-C3			1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E				RGR-HM-T2			1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG-DW-OD			2.00	DRESS EXTERNAL WHEEL		.02308		.053		
0050	E				KMG-GW-LK			1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG-OD-DH			1.00	GRIND .040 1 1/2 OD X 2		.14334		.164		
0070	E				RGR-GE-D3			1.50	DWELL (GAP GRINDER CHROM OD)OCCURRANCED FOR DIA		.02029		.035		
0080	E				RTL-MM-M3			6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042		
0090	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000			JA	01		15		.01		LABOR STANDARD HISTORY	.000	.000	.000		0
0010									07SEP83 REVIEW & UPDATE NO OCC. FACTOR CHG 0.19						
0011									14NOV84 2 YR REVIEW W/NO CHANGE						
0016									18MAR85 DOWN GRADED NOT MARKET BASKET						
0900									J.CALDWELL TECH MANEAA						

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 09/16/88 A-E046B-MM1-DY-M45 PAGE 0001

26338A F15 MLG L/H HW RCC MNPRB 4A4-22-3 86224

OPER SUB STEP	TECH D	S T L	S K	W #R K	F A C	PF FA DC	A/R SUPPORT ELEMENT	REV OCC FACT	<---------- DESCRIPTION ----------> STORED	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
RB011		S	E	JA EA 3		K	98194	.05	PERCENT ENGR 99.9	GRIND UPPER JURY LINK	1.00		.05	
0001				JA 01		00		.00		PART NUMBER/NSN	.000	.000	.000	0
0010									68A410794-1005	1620010403581				
0020									68A410794-1006	1620010403580				
0050				JA 01		15		1.00		1ST GRIND O.D.	.414	.062	.477	47
0010	E					RGR-SU-C2		.25	SET UP SMALL MED CYL GRINDERPRORATE OVER 4 PARTS		.29197		.083	
0020	E					RLA-HP-C3		1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0030	E					RGR-HM-T2		1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0040	E					KMG-DW-OD		2.00	DRESS EXTERNAL WHEEL		.02308		.053	
0050	E					KMG-GW-LK		1.00	LOCATE WHEEL TO POSITION		.06761		.077	
0060	E					KMG-OD-DA		1.00	GRIND .010 1 1/2 OD X 1		.04850		.055	
0070	E					RGR-GE-D2		1.50	DWELL (GAP GRINDER STEEL OD)OCCURRANCED FOR DIA		.01014		.017	
0080	E					RTL-MM-M3		6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042	
0090	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0120				JA 01		15		1.00		GRIND CHROME O.D.	.460	.069	.529	53
0010	E					RGR-SU-C2		.25	SET UP SMALL MED CYL GRINDERPRORATE OVER 4 PARTS		.29197		.083	
0020	E					RLA-HP-C3		1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0030	E					RGR-HM-T2		1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0040	E					KMG-DW-OD		2.00	DRESS EXTERNAL WHEEL		.02308		.053	
0050	E					KMG-GW-LK		1.00	LOCATE WHEEL TO POSITION		.06761		.077	
0060	E					KMG-OD-DF		1.00	GRIND .040 1 1/2 OD X 1		.07883		.090	
0070	E					RGR-GE-D3		1.50	DWELL (GAP GRINDER CHROM OD)OCCURRANCED FOR DIA		.02029		.035	
0080	E					RTL-MM-M3		6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042	
0090	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000				JA 01		15		.01		LABOR STANDARD HISTORY	.000	.000	.000	0
0010									07SEP83 REVIEW & UPDATE NO OCC. FACTOR CHG 0.09					
0011									14NOV84 2 YR REVIEW W/NO CHANGE					
0016									18MAR85 DOWN GRADED NOT MARKET BASKET					
0900									J.CALDWELL TECH MANEAA					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR
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SUB STEP	TECH T	S K	S #R	W A	F C	PF DC	A/R ELEMENT	REV FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY	PCT C
8E012	S	N	JA	EA	3	J	8.190	.10	PERCENT ENGR 75.9	GRIND RETRACT BOLT	1.40		.14		
0001			JA	01	15			.00		PART NUMBER/ NSN	.000	.000	.000		0
0010									62A410768-1001	1620003336550					
0070			JA	01	15			1.00		1ST GRIND O.D.	.588	.088	.677		48
0010	E				RGR	SU	C2	1.00	SET UP SMALL MED CYL GRINDER		.29197		.335		
0020	E				RLA	HP	C6	1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028		
0030	E				RGR	HM	T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG	DW	OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E				KMG	GW	LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG	OD	BD	1.00	GRIND .010 3/4D X 2 1/2 L		.05417		.062		
0070	E				RGR	GE	D2	1.00	DWELL (GAP GRINDER STEEL OD)		.01014		.011		
0080	E				RGR	HM	C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0160			JA	01	15			1.00		FINISH GRIND O.D.	.635	.095	.731		52
0010	N							1.00		S/U GRINDER > RGRSUC2 <	.29500		.339		
0020	E				RLA	HP	C6	1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028		
0030	E				RGR	HM	T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG	DW	OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E				KMG	GW	LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG	OD	BJ	1.00	GRIND .040 3/4 OD X 2 1/2		.08734		.100		
0070	E				RGR	GE	D3	1.00	DWELL (GAP GRINDER CHROM OD)		.02029		.023		
0080	E				RGR	HM	C2	1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000			JA	01	15			.01		LABOR STANDARD HISTORY	.000	.000	.000		0
0010									13SEP83 NEW INPUT-NO OCC FACTOR HISTORY						
0011									14NOV84 2 YR REVIEW W/NO CHANGE						
0016									18MAR85 DOWN GRADED NOT MARKET BASKET						
0900									J.CALDWELL TECH MANEAA						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR
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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 09/16/88 A-E046B-MM1-DY-M45 PAGE 0001

26338A F15 MLG L/H HW RCC MNPRB 4A4-22-3 86224

OPER SUB STEP	TECH D	S L	S K	W #R K	F A C	PF FA DC	A/R REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT	C
R5013	S	E	JA	EA	3		K 88197	.05	PERCENT ENGR 99.9	GRIND SPINDLE ASSY F-15M	1.80		.09		
0001			JA	01		00		.00		PART NUMBER/NSN	.000	.000	.000		0
0010									68A410624-1001	1620003337133					
0060			JA	01		15		1.00		1ST GRIND O.D.	.377	.057	.434		24
0010	E				RGR	SU	C2	.25	SET UP SMALL MED CYL GRINDERPRORATE OVER 4 PARTS		.29197		.083		
0020	E				RLA	HP	C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E				RGR	HM	T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG	DW	OD	2.00	DRESS EXTERNAL WHEEL		.02308		.053		
0050	E				KMG	GW	LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG	OD	AA	1.00	GRIND .010 1/2 DIA. X 1		.01617		.018		
0070	E				RGR	GE	D2	1.00	DWELL (GAP GRINDER STEEL OD)OCCURRANCED FOR DIA		.01014		.011		
0080	E				RTL	MM	M3	6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042		
0090	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0070			JA	01		15		1.00		1ST GRIND O.D.	.377	.057	.434		24
0010	E				RGR	SU	C2	.25	SET UP SMALL MED CYL GRINDERPRORATE OVER 4 PARTS		.29197		.083		
0020	E				RLA	HP	C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E				RGR	HM	T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG	DW	OD	2.00	DRESS EXTERNAL WHEEL		.02308		.053		
0050	E				KMG	GW	LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG	OD	AA	1.00	GRIND .010 1/2 DIA. X 1		.01617		.018		
0070	E				RGR	GE	D2	1.00	DWELL (GAP GRINDER STEEL OD)OCCURRANCED FOR DIA		.01014		.011		
0080	E				RTL	MM	M3	6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042		
0090	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0150			JA	01		15		1.00		GRIND CHROME O.D.	.407	.061	.469		26
0010	E				RGR	SU	C2	.25	SET UP SMALL MED CYL GRINDERPRORATE OVER 4 PARTS		.29197		.083		
0020	E				RLA	HP	C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E				RGR	HM	T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG	DW	OD	2.00	DRESS EXTERNAL WHEEL		.02308		.053		
0050	E				KMG	GW	LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG	OD	AF	1.00	GRIND .040 FROM 1/2D X 1		.03633		.041		
0070	E				RGR	GE	D3	1.00	DWELL (GAP GRINDER CHROM OD)OCCURRANCED FOR DIA		.02029		.023		
0080	E				RTL	MM	M3	6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042		
0090	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0160			JA	01		15		1.00		GRIND CHROME O.D.	.407	.061	.469		26
0010	E				RGR	SU	C2	.25	SET UP SMALL MED CYL GRINDERPRORATE OVER 4 PARTS		.29197		.083		
0020	E				RLA	HP	C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E				RGR	HM	T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG	DW	OD	2.00	DRESS EXTERNAL WHEEL		.02308		.053		
0050	E				KMG	GW	LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG	OD	AF	1.00	GRIND .040 FROM 1/2D X 1		.03633		.041		
0070	E				RGR	GE	D3	1.00	DWELL (GAP GRINDER CHROM OD)OCCURRANCED FOR DIA		.02029		.023		
0080	E				RTL	MM	M3	6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042		
0090	E				RJP	PW	R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000			JA	01		15		.01		LABOR STANDARD HISTORY	.000	.000	.000		0
0010									07SEP83 REVIEW & CHG OCC. FACTORS 0.10						
0011									14NOV84 2 YR REVIEW W/NO CHANGE						
0016									18MAR85 DOWN GRADED NOT MARKET BASKET						
0900									J.CALDWELL TECH MANEAA						

OPER SUB STEP	TECH D	S T L	S K K	W #R C	F A DC	PF FA ELEMENT	A/R REV SUPPORT FACT	OCC	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
RB014	S	E	JA	EA	3	K	88196	.05	PERCENT ENGR 99.9	GRD SWIVEL CRANK DRAG BOLT	1.12		.05		
0001			JA	01		00		.00		PART NUMBER/NSN	.000	.000	.000		0
0010									68A410637-1001 NSL						
0050			JA	01		15		1.00		1ST GRIND O.D.	.455	.068	.523		46
0010	E				RGR-SU-C2			.25	SET UP SMALL MED CYL GRINDER	PRORATE OVER 4 PARTS	.29197		.083		
0020	E				RLA-HP-C3			1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E				RGR-HM-T2			1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG-DW-OD			2.00	DRESS EXTERNAL WHEEL		.02308		.053		
0050	E				KMG-GW-LK			1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG-OD-DC			1.00	GRIND .010 1 1/2 OD X 2		.08884		.102		
0070	E				RGR-GE-D2			1.50	DWELL (GAP GRINDER STEEL OD)	OCCURRANCED FOR DIA	.01014		.017		
0080	E				RTL-MM-M3			6.00	MIC O D FIRST MEASUREMENT	2 PLACES 3 CHECKS EACH	.00616		.042		
0090	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0120			JA	01		15		1.00		CHROME GRIND O.D.	.524	.079	.603		54
0010	E				RGR-SU-C2			.25	SET UP SMALL MED CYL GRINDER	PRORATE OVER 4 PARTS	.29197		.083		
0020	E				RLA-HP-C3			1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E				RGR-HM-T2			1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG-DW-OD			2.00	DRESS EXTERNAL WHEEL		.02308		.053		
0050	E				KMG-GW-LK			1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG-OD-DH			1.00	GRIND .040 1 1/2 OD X 2		.14334		.164		
0070	E				RGR-GE-D3			1.50	DWELL (GAP GRINDER CHROM OD)	OCCURRANCED FOR DIA	.02029		.035		
0080	E				RTL-MM-M3			6.00	MIC O D FIRST MEASUREMENT	2 PLACES 3 CHECKS EACH	.00616		.042		
0090	E				RJP-PW-R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000			JA	01		15		.01		LABOR STD HISTORY	.000	.000	.000		0
0010									07SEP83 REVIEW & UPDATE NO OCC. FACTOR CHG 0.09						
0011									14NOV84 2 YR REVIEW W/NO CHANGE						
0012									11MAR85 DOWN GRADED NOT MARKET BASKET CHANG OCC.10						
0900									J.CALDWELL TECH MANEAA						

TO INTERROGATE LABOR STANDARDS, INPUT

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26338A F15 MLG L/H MW RCC MNFRB 4A4-22-3 86224

SUB STEP	TECH D	S T	S K	W R	F A	PF C	A/R FA	REV DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
RB019	S	E	JA	EA	3			J	88190	.10	PERCENT ENGR 99.9	GRIND JURY BRACE APEX PIN	2.27		.22		
0001			JA	01		15				.00		PART NUMBER/NSN	.000	.000	.000		0
0010											68A410755-2005	1620003337138					
0050			JA	01		15				1.00		1ST GRIND LARGE O.D.	.452	.068	.520		23
0010	E				RGR	SU	C2			.50	SET UP SMALL MED CYL GRINDER	PRORATE W/SUB OP 0055	.29197		.167		
0020	E				RLA	HP	C6			.50	LOAD&UNLOAD SML PART-CENTERS	PRORATE W/SUB OP 0055	.02466		.014		
0030	E				RGR	HM	T2			.50	ADJUST TAPER - GAP GRINDER	PRORATE W/SUB OP 0055	.02632		.015		
0040	E				KMG	DW	OD			1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E				KMG	GW	LK			1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG	OD	DC			1.00	GRIND .010 1 1/2 OD X 2		.08884		.102		
0070	E				RGR	GE	D2			1.00	DWELL (GAP GRINDER STEEL OD)		.01014		.011		
0080	E				RGR	HM	C2			1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090	E				RJP	PW	R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0055			JA	01		15				1.00		1ST GRIND SMALL O.D.	.492	.074	.567		25
0010	E				RGR	SU	C2			.50	SET UP SMALL MED CYL GRINDER	PRORATE W/SUB OP 0050	.29197		.167		
0020	E				RLA	HP	C6			.50	LOAD&UNLOAD SML PART-CENTERS	PRORATE W/SUB OP 0050	.02466		.014		
0030	E				RGR	HM	T2			.50	ADJUST TAPER - GAP GRINDER	PRORATE W/SUB OP 0050	.02632		.015		
0040	E				KMG	DW	OD			1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E				KMG	GW	LK			1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG	OD	DE			1.00	GRIND .010 1 1/2 OD X 3		.12934		.148		
0070	E				RGR	GE	D2			1.00	DWELL (GAP GRINDER STEEL OD)		.01014		.011		
0080	E				RGR	HM	C2			1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090	E				RJP	PW	R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0120			JA	01		15				1.00		FINISH GRIND LARGE O.D.	.516	.078	.594		26
0010	E				RGR	SU	C2			.50	SET UP SMALL MED CYL GRINDER	PRORATE W/SUB OP 0125	.29197		.167		
0020	E				RLA	HP	C6			.50	LOAD&UNLOAD SML PART-CENTERS	PRORATE W/SUB OP 0125	.02466		.014		
0030	E				RGR	HM	T2			.50	ADJUST TAPER - GAP GRINDER	PRORATE W/SUB OP 0125	.02632		.015		
0040	E				KMG	DW	OD			1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E				KMG	GW	LK			1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG	OD	DH			1.00	GRIND .040 1 1/2 OD X 2		.14334		.164		
0070	E				RGR	GE	D3			1.00	DWELL (GAP GRINDER CHROM OD)		.02029		.023		
0080	E				RGR	HM	C2			1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090	E				RJP	PW	R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0125			JA	01		15				1.00		FINISH GRIND SMALL O.D	.516	.078	.594		26
0010	E				RGR	SU	C2			.50	SET UP SMALL MED CYL GRINDER	PRORATE W/SUB OP 0120	.29197		.167		
0020	E				RLA	HP	C6			.50	LOAD&UNLOAD SML PART-CENTERS	PRORATE W/SUB OP 0120	.02466		.014		
0030	E				RGR	HM	T2			.50	ADJUST TAPER - GAP GRINDER	PRORATE W/SUB OP 0120	.02632		.015		
0040	E				KMG	DW	OD			1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E				KMG	GW	LK			1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG	OD	DH			1.00	GRIND .040 1 1/2 OD X 2		.14334		.164		
0070	E				RGR	GE	D3			1.00	DWELL (GAP GRINDER CHROM OD)		.02029		.023		
0080	E				RGR	HM	C2			1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090	E				RJP	PW	R1			1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000			JA	01		15				.01		LABOR STANDARD HISTORY	.000	.000	.000		0
0010											14SEP83 NEW INPUT-NO OCC FACTORS						
0011											14NOV84 2 YR REVIEW W/NO CHANGE						
0016											18MAR85 DOWN GRADED NOT MARKET BASKET						
0900											J.CALDWELL TECH MANEAA						

SUB STEP	TECH D	S L	S W K	F #R C	PF A FA DC	A/R REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
RB026	S	E	JA	EA	3	J 88202	.33	PERCENT ENGR 99.9	GRD.REPR.HIGH PRESSURE PSTN.	4.16		1.37		
0001			JA	01	00		.00		PART NUMBER/N.S.N.	.000	.000	.000		0
0010								68A410790-2001	1620003654003					
0070			JA	01	15		1.00		IST.GRD.PISTON LANDS O.D.	.805	.121	.926		22
0010	E				RGR-SU-C2		.25	SET UP SMALL MED CYL GRINDER	PRORATE OVER 4 PARTS	.29197		.083		
0020	E				RLA-HP-C3		1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E				RGR-HM-T2		1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG-DW-OD		1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E				KMG-GW-LK		1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG-OD-LE		1.00	GRIND .010 FROM 5 IN OD X 3		.42668		.490		
0070	E				RGR-GE-D2		5.00	DWELL (GAP GRINDER STEEL OD)	OCCURRANCED FOR DIA	.01014		.058		
0080	E				RTL-MM-M3		6.00	MIC O D FIRST MEASUREMENT	2 PLACES 3 CHECKS EACH	.00616		.042		
0090	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0080			JA	01	15		.05		IST.GRD.PISTON LANDS I.D.	1.346	.010	.077		2
0010	E				RGR-SU-I1		.25	S/U SMALL INTERNAL GRINDER	PRORATE OVER 4 PARTS	.49838		.143		
0020	E				RLA-HP-C4		1.00	IRREG PART IN 4 JAW CHUCK		.22097		.254		
0030	E				RGR-HM-T2		1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG-DW-ID		4.00	DRESS INTERNAL WHEEL		.02458		.113		
0050	E				KMG-GW-LK		1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG-ID-LE		1.00	GRIND OUT .010 5 ID X 3		.60998		.701		
0070	E				RGR-GE-D2		5.00	DWELL (GAP GRINDER STEEL OD)		.01014		.058		
0080	E				RGR-HM-C2		1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090	E				ZIT-VI-B2		1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.064		
0100	E				RBW-BU-P1		.50	BUTTERFLY POLISH BUSHING I D		.00333		.001		
0110	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0090			JA	01	15		.67		IST.GRD.PISTON GROOVE O.D.	.761	.077	.587		14
0010	E				RGR-SU-C2		.25	SET UP SMALL MED CYL GRINDER	PRORATE OVER 4 PARTS	.29197		.083		
0020	E				RLA-HP-C3		1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E				RGR-HM-T2		1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG-DW-OD		1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E				KMG-GW-LK		1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG-OD-KE		1.00	GRIND .010 4 1/2 OD X 3		.38784		.446		
0070	E				RGR-GE-D2		4.50	DWELL (GAP GRINDER STEEL OD)	OCCURRANCED FOR DIA	.01014		.052		
0080	E				RTL-MM-M3		6.00	MIC O D FIRST MEASUREMENT	2 PLACES 3 CHECKS EACH	.00616		.042		
0090	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0100			JA	01	15		.05		IST.GRD.PISTON GROOVE I.D.	1.147	.009	.066		2
0010	E				RGR-SU-I1		.25	S/U SMALL INTERNAL GRINDER	PRORATE OVER 4 PARTS	.49838		.143		
0020	E				RLA-HP-C4		1.00	IRREG PART IN 4 JAW CHUCK		.22097		.254		
0030	E				RGR-HM-T2		1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E				KMG-DW-ID		4.00	DRESS INTERNAL WHEEL		.02458		.113		
0050	E				KMG-GW-LK		1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E				KMG-ID-HE		1.00	GRIND OUT .010 3.5 ID X 3		.42548		.489		
0070	E				RGR-GE-D2		3.50	DWELL (GAP GRINDER STEEL OD)		.01014		.040		
0080	E				RGR-HM-C2		1.00	HANDLE & MEAS LENGTH 1 TO 5		.08102		.093		
0090	E				ZIT-VI-B2		1.00	VISUAL INSP MEDIUM CYL I.D.		.05578		.064		
0100	E				RBW-BU-P1		.50	BUTTERFLY POLISH BUSHING I D		.00333		.001		
0110	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
			JA	01	15		1.00		FINISH GRD.LANDS O.D.	1.116	.167	1.283		31
0010	E				RGR-SU-C2		.25	SET UP SMALL MED CYL GRINDER	PRORARE OVER 4 PARTS	.29197		.083		

0020	E	RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW			.09095		.104	
0030	E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER			.02632		.030	
0040	E	KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL			.02308		.026	
0050	E	KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION			.06761		.077	
0060	E	KMG-OD-LK	1.00	GRIND .040 FROM 5 IN OD X 3			.68668		.789	
0070	E	RGR-GE-D3	5.00	DWELL (GAP GRINDER CHROM OD)OCCURRANCED FOR DIA			.02029		.116	
0080	E	RTL-MM-M3	6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH			.00616		.042	
0090	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0190	JA 01	15	.33	FINISH GRD.LAND I.D.			1.436	.071	.545	13
0010	E	RGR-SU-I1	.25	S/U SMALL INTERNAL GRINDER PRORATE OVER 4 PARTS			.49838		.143	
0020	E	RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK			.22097		.254	
0030	E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER			.02632		.030	
0040	E	KMG-DW-ID	4.00	DRESS INTERNAL WHEEL			.02458		.113	
0050	E	KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION			.06761		.077	
0060	E	KMG-ID-GK	1.00	GRIND OUT .040 3 ID X 3			.68914		.792	
0070	E	RGR-GE-D3	3.00	DWELL (GAP GRINDER CHROM OD)			.0202>		70	
0080	E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5			.08102		.093	
0090	E	ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.			.05578		.064	
0100	E	RBW-BU-P1	.50	BUTTERFLY POLISH BUSHING I D			.00333		.001	
0110	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0240	JA 01	15	.67	FINISH GRIND GROOVE O.D.			.761	.077	.587	14
0010	E	RGR-SU-C2	.25	SET UP SMALL MED CYL GRINDER PRORATE OVER 4 PARTS			.29197		.083	
0020	E	RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW			.09095		.104	
0030	E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER			.02632		.030	
0040	E	KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL			.02308		.026	
0050	E	KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION			.06761		.077	
0060	E	KMG-OD-KE	1.00	GRIND .010 4 1/2 OD X 3			.38784		.446	
0070	E	RGR-GE-D2	4.50	DWELL (GAP GRINDER STEEL OD)OCCURRANCED FOR DIA			.01014		.052	
0080	E	RTL-MM-M3	6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH			.00616		.042	
0090	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0250	JA 01	15	.05	FINISH GRIND GROOVE I.D.			1.564	.012	.090	2
0010	E	RGR-SU-I1	.25	S/U SMALL INTERNAL GRINDER PRORATE OVER 4 PARTS			.49838		.143	
0020	E	RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK			.22097		.254	
0030	E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER			.02632		.030	
0040	E	KMG-DW-ID	4.00	DRESS INTERNAL WHEEL			.02458		.113	
0050	E	KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION			.06761		.077	
0060	E	KMG-ID-HK	1.00	GRIND OUT .040-3.5 ID X 3			.80697		.928	
0070	E	RGR-GE-D3	3.50	DWELL (GAP GRINDER CHROM OD)			.02029		.081	
0080	E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5			.08102		.093	
0090	E	ZIT-VI-B2	1.00	VISUAL INSP MEDIUM CYL I.D.			.05578		.064	
0100	E	RBW-BU-P1	.50	BUTTERFLY POLISH BUSHING I D			.00333		.001	
0110	E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
9000	JA 00	15	.00	LABOR STANDARD HISTORY			.000	.000	.000	0
0001				28AUG86 INITAL INPUT EST. NEW REQUIREMENT						
0010				20JUL88 OCC.FAC.CHGE,OLD STD..20						
0900				J.CALDWELL TECH MANEL						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD MROP NR
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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 08/01/88 A-E046B-MM1-DY-M45 PAGE 0001

26337A F15 MLG R/H HB RCC MNPGP 4A4-22-3 86224

STEP	TECH D	S T L	S K	W #R K	F A C	PF FA DC	A/R REV SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
00010	E	N	HB	EA	5	J	88204	1.00	PERCENT ENGR .0	STRUT ASSY F-15	11.60		11.60		
0001			HB	01	00			.00		PART NUMBER /NSN	.000	.000	.000	0	
0010									68A410501-2007	1620010360335					
0020									68A410501-2008	1620010360336					
0030									69A410501-2009	1620010672791					
0040									68A410501-2010	1620010799928					
0050									68A410501-2011	1620011671000					
0060									68A410501-2012	1620011670999					
0501			HB	01	21			1.00		PRE CLEAN	1.000	.210	1.210	10	
0010		N						1.00		CLEAN	1.00000		1.210		
0502			HB	01	21			1.00		OK CLOSE/ASSEMBLE	6.000	1.260	7.260	63	
0010		N						1.00		ASSY	6.00000		7.260		
0504			HB	01	21			1.00		CHECK STROKE	.710	.149	.859	7	
0010		N						1.00		CHECK STROKE	.71000		.859		
0505			HB	01	21			1.00		FINGER LOCK CHECK	1.000	.210	1.210	10	
0010		N						1.00		CHECK	1.00000		1.210		
0506			HB	01	21			1.00		PRESSURE TEST	.880	.185	1.065	9	
0010		N						1.00		TEST	.88000		1.064		
9000			HB	01	21			.01		LABOR STD HISTORY	.000	.000	.000	0	
0010									15MAR83 UPDATE E STD 2 YR REVIEW	8.14					
0011									14NOV84 2 YR REVIEW W/NO CHANGE						

TO INTERROGATE LABOR STANDARDS, INPUT

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                    LABOR STANDARD  OPERATION RESOURCE STANDARD AND METHOD ANALYSIS   09/01/88    A-E0463-MM1-DY-M45  PAGE  0001
      26337A    F15 MLG R/H HW                                RCC MNPGP              4A4-22-3              86224
DF    TECH S S   W F PF A/R REV
         T K   #R A FA SUPPORT   OCC <-------------------- DESCRIPTION ---------------------> BASE    PFD     STD          A
      STEP D L   K C DC ELEMENT  FACT          STORED                    SUPPLEMENTAL        HOURS   TIME    HOURS   DLY PCT C
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FM000    S  E DI EA 5    K 88204  1.00 PERCENT ENGR 99.9          MATCH UP STRUT ASSY          .90             .90
  0001       DI 01   00           .00                            PART NUMBER /NSN             .000   .000     .000       0
     0010                             68A410501-2007        1620010360335
     0020                             68A410501-2008        1620010360336
     0030                             69A410501-2009        1620010672791
     0040                             68A410501-2010        1620010799928
     0050                             68A410501-2011        1620011671000
     0060                             68A410501-2012        1620011670999
  0010       DI 01   21           1.00                            MATCH UP                     .750   .158     .908       100
     0110 E          RLG-MU-01    1.00 MATCH UP PARTS FOR ASSEMBLY                            .52681           .637
     0120 E          GCE-JP-TO    1.00 T.O. RESEARCH                                          .19359           .234
     0130 E          RJP-PW-R1    2.00 REM RPL PAPRWRK SIGN OFF DOC OCC FOR NO. 958 IN PACKAGE .01001           .024
     0140 E          RJP-PW-R1    1.00 REM RPL PAPRWRK SIGN OFF DOC                           .01001           .012
  9000       DI 01   21           .01                          LABOR STANDARD HISTORY         .000   .000     .000       0
     0010                          15MAR83 PRIOR HISTORY ON OO-ALC FORM 494
     0011
     0020                                 ADD SUB OP 0002 PARTS HANDLING NON
     0030                                 ROUTED PARTS
     0031                          14NOV84 2 YR REVIEW W/NO CHANGE
     0033                          18MAR85 DOWN GRADED NOT MARKET BASKET
     0900                           J.CALDWELL TECH MANEAA


TO INTERROGATE LABOR STANDARDS, INPUT

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 08/01/88 A-E0463-MM1-DY-M45 PAGE 0001

26337A F15 MLG R/H HW RCC MNPGP 4A4-22-3 86224

TCH STEP	S D	S T L	W K	F R	PF A	A/R C	REV DC	SUPPORT ELEMENT	OCC FACT	DESCRIPTION STORED	DESCRIPTION SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT	C
FN002	E	N	DI	EA	5		J	88204	1.00	PERCENT ENGR .0	MATCH UP PISTON/HEAD F-15	.20		.20		
0001			DI	01		00			.00		PART NUMBER/NSN	.000	.000	.000	0	
0010										68A410704-1001	1620003486501					
0020										68A410704-1002	1620003486502					
0030										68A410704-1011	1620018033404					
0040										68A410704-1012	1620018033407					
0050										68A410704-1005	1620018033401					
0060										68A410704-1006	1620018188799					
0257			DI	01		21			1.00		PISTON & HEAD MATCH UP	.167	.035	.202	100	
0010	N								1.00		MATCH UP	.16700		.202		
9000			DI	01		00			.00		LABOR STANDRD HISTORY	.000	.000	.000	0	
0900										8 APR. 1988 RICHARD G. MARTIN MANEL-73357-MRPII						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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